Pab

AUG 14 1996

CERTIFIED MAIL
RETURN RECEIPT REQUESTED

Mr. Saburo Inui
Vice President
Toyota Motor Corporate Services
of North America, Inc.
1850 M Street, NW
Washington, DC 20036

NSA-111paw
96V-129

Dear Mr. Inui:

This acknowledges receipt of your Defect Information Report dated July 9, 1996, submitted in accordance with 49 CFR Part 573, "Defect and Noncompliance Reports." This recall involves 90,000 Toyota Motor Corporate Services of North America, Inc. (Toyota) 1995 through 1996 Tacoma 2WD model vehicles. Under certain driving conditions, the front suspension can crack leading to the failure of the support. **The assigned ID Number for this recall campaign is *96V-129*.**

Toyota is responsible for the remedy of these vehicles from this date forward, regardless of vehicle age, mileage, or ownership. You should know that the agency provides a listing of safety recalls to the media at the end of each month. This recall will be a part of that listing.

ADDITIONAL INFORMATION REQUIRED

In order for us to complete our file on this matter, please provide the manufacturing dates of the vehicles involved in this recall campaign.

Please provide this information, referencing the National Highway Traffic Safety Administration's identification codes on page 1 of this letter, to this office by **September 11, 1996.**

NOTIFICATION TO PURCHASERS

In accordance with Part 577, amended July 7, 1995, a draft owner notification letter must be submitted for review prior to mailing.

QUARTERLY STATUS REPORTS

As stated in Part 573.6, submission of the first of six consecutive quarterly status reports is required within 1 month after the close of the calendar quarter **in which notification to purchasers occurs**. For instance, the current calendar quarter began on July 1 and ends on September 30, 1996. As noted in your report, owner notification is expected to begin in August 1996. Therefore, the first quarterly report is due by October 30, 1996. In the case where the recall appears to be completed, quarterly reporting is required until your company is notified otherwise by this office. The following chart provides due dates for each of the six quarterly reports.

QUARTER	QUARTER BEGINS	QUARTER ENDS	DUE DATE
1st Quarter	July 1, 1996	September 30, 1996	October 30, 1996
2nd Quarter	October 1, 1996	December 31, 1996	January 30, 1997
3rd Quarter	January 1, 1997	March 31, 1997	April 30, 1997
4th Quarter	April 1, 1997	June 30, 1997	July 30, 1997
5th Quarter	July 1, 1997	September 30, 1997	October 30, 1997
6th Quarter	October 1, 1997	December 31, 1997	January 30, 1998

If you have any questions, please contact Mrs. Pat Wallace or Mrs. Barbara Hayes at (202) 366-5232 or fax at (202) 366-7882.

Sincerely,

/S/

Jonathan D. White, Chief
Recall Analysis Division
Office of Defects Investigation
Safety Assurance

TOYOTA

TOYOTA MOTOR CORPORATE SERVICES OF NORTH AMERICA, INC.

WASHINGTON OFFICE
1850 M STREET, N.W., WASHINGTON, D.C. 20036

TEL: (202) 775-1707
FAX: (202) 463-8513

July 9, 1996

96F-129 (U1)

RECEIVED
96 JUL 10 AM 9:42
OFFICE
DEFECTS INVESTIGATION

Mr. Michael Brownlee
Associate Administrator for Safety Assurance – NSA-01
National Highway Traffic Safety Administration
400 Seventh Street, S.W.
Washington, D.C. 20590

Re: Toyota Tacoma Front Suspension
Part 573, Defect Information Report

Dear Mr. Brownlee:

In accordance with the requirements of the National Traffic and Motor Vehicle Safety Act of 1966 and 49 CFR Part 573, on behalf of Toyota Motor Corporation ["TMC"], we hereby submit a Defect Information Report concerning a safety recall of certain 1995 to 1996 model Toyota Tacoma vehicles to address a possible front suspension support problem.

Should you have any questions about this report, please contact Mr. Jim Ohashi of my staff at (202) 775-1707.

Sincerely,

TOYOTA MOTOR CORPORATE
SERVICES OF NORTH AMERICA, INC.

Saburo Inui
Vice President

SI:ds
Attachment

DEFECT INFORMATION REPORT

96V-129 (02)

1. Vehicle Manufacturer Name:
TABC, Inc. ["TABC"]
6375 Paramount Blvd.
Long Beach, CA 90801

Affiliated U.S. Sales Company
Toyota Motor Sales, USA, Inc. ["TMS"]
19001 South Western Avenue
Torrance, CA 90509

2. Identification of Affected Vehicles:
Based on production records, we have determined the affected vehicle population as set forth in the table below.

Make/ Car Line	Model Year	Manufac-turer	VIN (1)		Production Period
			VDS	VIS	
Toyota Tacoma 2WD	1995-1996	TABC Inc.	TBD (2)	TBD (2)	TBD (2)

Note :
(1) Although the involved vehicles are within the above VIN ranges, not all vehicles in these ranges were sold in the U.S.

(2) Information of VIN and production period will be reported to NHTSA as soon as it is available.

3. Total Number of Vehicles Potentially Affected:

Approximately 90,000 units

4. Percentage of Vehicles Estimated to Actually Experience Malfunction:

Unknown

5. Description of Problem:

If the front suspension of the subject vehicle is repeatedly exposed to simultaneous up-and-down and back-and-forth motions, e.g. driving over "speed bumps" under severe braking, the front suspension support may crack, which could ultimately lead to failure of the support. This could result in the loss of vehicle control.

6 Chronology of Principal Events:

February 1996 through April 1996

TMC received information from TMS concerning a failed front suspension support on a 1995 model Tacoma, which resulted in inability to drive the vehicle. TMC then conducted a review of the production process as well as an investigation of the recovered part. However, no abnormalities were found at that time.

May 1996 through June 1996

After receiving some additional information of a similar nature, TMC conducted replicate tests to verify if the condition was due to a vehicle defect. Although no problems were found in the normal simulation test, a failure which was similar to that of the recovered parts was replicated in an inordinately severe test condition.

July 1996

After analysis of the results of its investigation, Toyota determined that the front suspension support of the subject vehicles may have insufficient strength under certain very severe driving conditions. Therefore, it decided to conduct a safety recall, and production was changed to strengthen the subject component.

Toyota is aware of no injuries or accidents relating to this problem.

7. Description of Corrective Repair Action:

All known owners of the subject vehicles will be notified by first class mail to return their vehicles to a Toyota dealer for repair of the suspension support at no cost.

8. Recall Schedule:

Due to lack of special repair tools and repair specialist availability, mailing of the owner notifications will commence at the end of August and be completed around the middle of September 1996.

Copies of the owner notification and dealer instructions will be submitted as soon as they are available.

96V-129

TOYOTA

SSC T06

Technical Instructions

TOYOTA

Toyota Motor Sales, U.S.A., Inc.
19001 South Western Avenue
P.O. Box 2991
Torrance, CA 90509-2991
(310) 618-4000
(310) 618-7800 Fax

TO: ALL TOYOTA DEALER PRINCIPALS,
SERVICE MANAGERS, PARTS MANAGERS

SUBJECT: SPECIAL SERVICE CAMPAIGN - T06
(1995-1996 TACOMA FRONT SUSPENSION SUPPORT)

As previously communicated, Toyota will initiate a Special Service Campaign to install a reinforcement kit on the front suspension supports of 1995 and certain 1996 model year Tacoma 4x2 vehicles.

Toyota has determined that if the front suspension of 1995 and certain 1996 model year Tacoma 4X2's are subjected to certain repeated driving conditions, such as simultaneous vertical and horizontal loading, (e.g. driving over a speed bump under severe braking), it may develop a crack, which could ultimately lead to failure of the front suspension support, possibly resulting in the loss of vehicle control.

The following information is provided to inform you and your staff of the campaign schedule and your degree of involvement.

As required by Federal Regulation, dealers are not to deliver any new vehicle acquired in their inventory which is involved in a safety recall until the necessary modification has been performed. Consequently, it is vital NOT to deliver any Tacoma 4X2 vehicles until they have been modified.

1. Owner Notification Letter Mailing Date

   August, 1996 (copy attached)

2. Identification of Involved Vehicles and Modification Procedures

   Refer to the enclosed Technical Instructions.

3. Special Service Campaign Kit

A Special Service Campaign kit which includes the necessary SST's and an initial supply of chemicals will be shipped to each dealer at no charge.

Contents of the Campaign Kit:

Coil Spring Compressor SST (P/N: 09727-22011-ST)	2
Spatter Protector	2 Upper and 2 Lower Shields
Suspension Support for Welding Practice	1 Piece
Suspension Support Mounting Plate	1 Piece
Reinforcement Plates for Welding Practice	2 Pieces (For Left and Right Sides)
Return Shipment Box for Suspension Support	1
Pre-addressed, Prepaid 2nd Day Air Shipping Label	1
Plastic Zip-lock Bag for Welding Technician Qualification Test Record Form	1
MAGNAFLUX® Spotcheck Kit	1 Kit containing 3 Chemicals
3M® Weld-thru Coating (3M® P/N: 051131-05913)	1 Can
Dealer Sales and Service Informational Video	1

INDEMNIFICATION FOR CAMPAIGN SERVICES RENDERED

Toyota Motor Sales, U.S.A., Inc. agrees to assume the defense of the **DEALER** and to indemnify and hold it harmless solely with respect to inspections, corrections and/or modifications which are performed upon vehicles pursuant to this Special Service Campaign subject to the following conditions:

DEALER agrees that trained personnel, including professional welders where necessary, will perform all appropriate inspections, corrections and/or modifications, including disassembly and re-assembly of components, in compliance with all of the directives set forth in the attached Special Service Campaign T06 Technical Instructions.

4. Parts Ordering

Part No.	Part Name	Description	Quantity/vehicle
04006-13135	Reinforcement Kit	4 Reinforcement Plates	1 Kit
94184-61000	Nut	For Shock Absorber and Stabilizer Bar	4
95381-03220	Cotter Pin	Tie Rod End Cotter Pin	2

Parts supply is anticipated to be adequate for launch. The necessary parts can be ordered through your facing PDC. The reinforcement kit as well as the nuts will be **MANUALLY ALLOCATED** based on each dealer's involved owner list for this campaign.

5. Reimbursement Procedures

Submit Special Service Campaign claims following the procedures described in the Toyota Warranty Policy & Procedures Manual. The operation codes to be used for this campaign are as follows:

(1) FOR ACTUAL VEHICLE MODIFICATION

SSC #	Op. Code	Description	Flat Rate Hour
T06	6501G1	Disassembly, Magnaflux Inspection, Refinishing, Reassembly and Alignment.(With ABS)	4.4 hrs/vehicle
	6501G2	Disassembly, Magnaflux Inspection, Refinishing, Reassembly and Alignment.(Without ABS)	4.3 hrs/vehicle
	*6501G4	Disassembly, Magnaflux Inspection, Welding Reinforcement Plates, Refinishing, Reassembly and Alignment.(With ABS)	6.4 hrs/vehicle
	*6501G5	Disassembly, Magnaflux Inspection, Welding Reinforcement Plates, Refinishing, Reassembly and Alignment.(Without ABS)	6.3 hrs/vehicle

*Op. Codes to be used if welding is performed by dealer personnel. If welding is performed by outside company, use the 6501G1 or 6501G2 Op. Code plus the sublets shown below as applicable:

- Include price of $5.00 per vehicle for special primer, paint and MAGNAFLUX® chemicals under sublet type "WD".
- Include actual rental vehicle reimbursement under sublet type "ZZ".
- Include actual expense incurred for welding reinforcement plates on vehicle under sublet type "WD".

NOTE: The above flat rate time includes 0.1 hours of administrative cost per unit for the dealership.

(2) FOR PRACTICE WELDING ONLY

Op. Code	Description	Flat Rate Hour
6501G6	Practice weld with dealer personnel*	1.0 hr/practice

- Use default Vehicle Identification Number: **4TAUN41B199999999.**
- Date of First Use: **08-01-1996**.
- Claim type: "**SC**".
- SSC Number: "**T06**".

* If practice welding is performed by outside company, use sublet as shown below:
- Include actual expense incurred for practice welding under sublet type "WD".

NOTE: The above flat rate time includes 0.1 hours of administrative cost per unit for the dealership.

6. Disclosure Label

To inform potential buyers that an involved new vehicle has been modified it will be necessary for you to affix a disclosure label, sent to you separately, to each modified new vehicle in your inventory. This will apply to new vehicles that have been modified at dealerships or have been received at dealerships with the modification already performed. The label must be affixed on the passenger's side window above the Monroney label and must not be removed from the vehicle until it is first sold at retail.

Please review this entire package with your Service and Parts staff to familiarize them with the proper step-by-step procedure and implement this Special Service Campaign to ensure customer satisfaction.

Thank you for your cooperation.
TOYOTA MOTOR SALES, U.S.A., INC.

Enclosures

SSC T06 - 1995 to 1996 TACOMA 4X2 VEHICLE FRONT SUSPENSION SUPPORT SAFETY RECALL NOTICE

Dear Toyota Owner:

This notice s being sent to you in accordance with the requirement of the National Traffic and Motor Vehicle Safety Act. Toyota has determined that a defect related to the front suspension supports exists in 1995 and certain 1996 model year Tacoma 4X2 vehicles.

WHAT IS THE PROBLEM?

If the front suspension supports of 1995 and certain 1996 model year Tacoma 4X2's are subjected to certain repeated driving conditions, such as simultaneous vertical and horizontal loading, (e.g. driving over a speed bump under severe braking), it may develop a crack, which could ultimately lead to failure of the front suspension support, possibly resulting in the loss of vehicle control.

WHAT WILL TOYOTA DO?

Any Toyota dealer will install a reinforcement kit to the front suspension supports at **NO COST** to you.

WHAT SHOULD YOU DO?

Contact any authorized Toyota dealer and make an appointment to have the necessary modification performed as soon as possible.

The labor time for installation of the reinforcement kit is approximately 6 hours. However, depending upon the dealer's work schedule, it may be necessary to make your vehicle available for a longer period of time.

Please present this notice to the dealer when you bring the vehicle in for the repair.

If you no longer own the vehicle, please indicate so on the enclosed postage paid form, providing us with the name and address of the new owner.

WHAT IF YOU HAVE OTHER QUESTIONS?

Please contact any Toyota dealer or call the Toyota Customer Assistance Center at 1-800-331-4331.

If you believe that the dealer or Toyota has failed or is unable to remedy the defect within a reasonable time, you may submit a complaint to the Administrator, National Highway Traffic Safety Administration, 400 Seventh Street S.W., Washington, D.C. 20590, or call the toll free Auto Safety Hot Line at 800-424-9393 (Washington, D.C. area residents may call 366-0123).

We have sent this notice in the interest of your continued satisfaction with our products and we sincerely regret any inconvenience this condition may have caused you.

Thank you for driving a Toyota.

Sincerely,

TOYOTA MOTOR SALES, U.S.A., INC.
CORPORATE PRODUCT TECHNICAL DEPARTMENT

SSC TO6

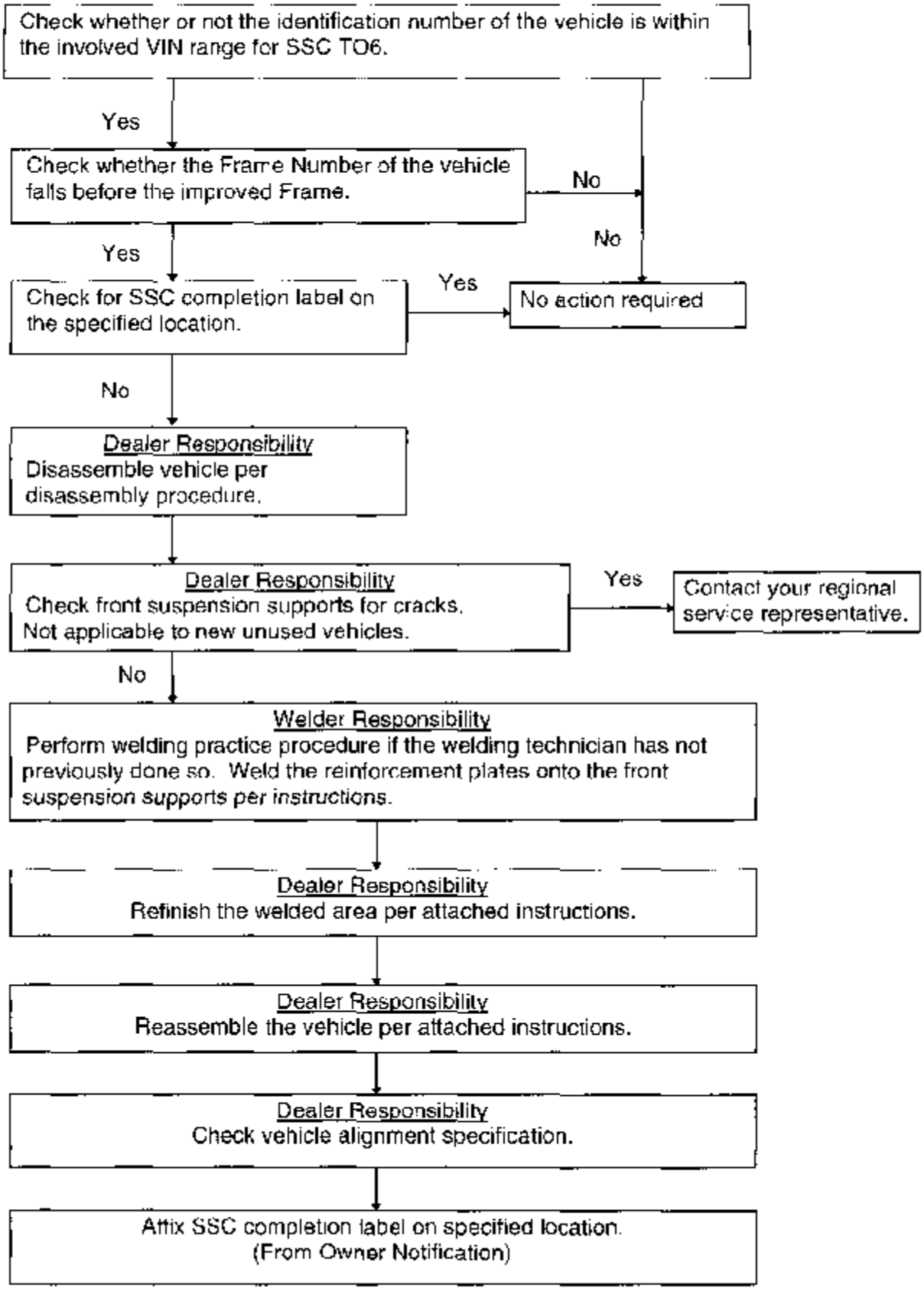
Technical Instructions

1. INVOLVED VEHICLE IDENTIFICATION AND EQUIPMENT REQUIREMENTS
2. DISASSEMBLY PROCEDURE
3. DYE CHECK PROCEDURE
4. SELECTING WELDING TECHNICIANS
5. WELDING PRACTICE
6. WELDING REINFORCEMENT PLATES
7. CLEANING AND REFINISHING
8. REASSEMBLY AND ALIGNMENT

1

INVOLVED VEHICLE IDENTIFICATION AND EQUIPMENT REQUIREMENTS

✧ Operation Flow Chart



INVOLVED VEHICLE IDENTIFICATION & EQUIPMENT REQUIREMENTS

1. CHECK VEHICLE INVOLVEMENT BY VIN

Check the VIN range to determine if the vehicle is involved in SSC T06. If the vehicle is outside of the VIN range it is not involved.

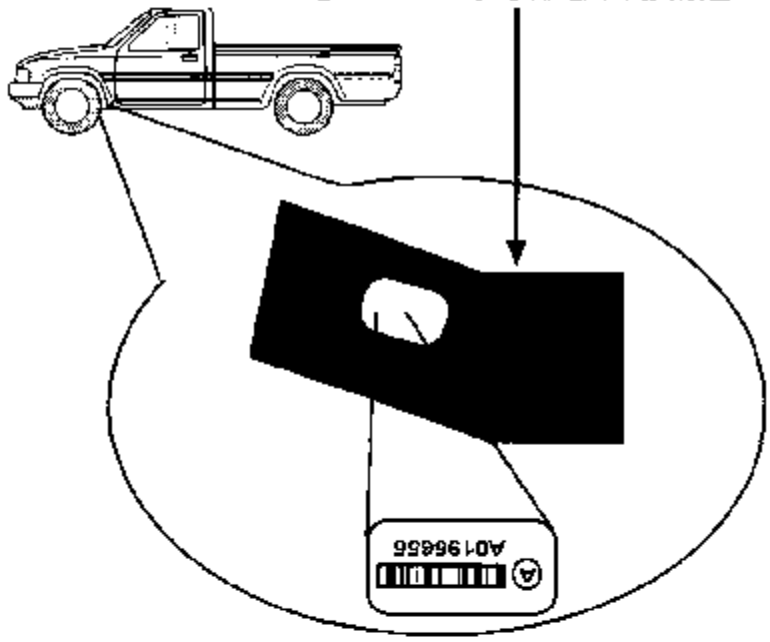
Model	VDS 1995	VDS 1996	Transmission	VIN Ranges*
Tacoma 4x2	4TAUN41B	4TANL42N	Manual	Z000001 - Z196728
			Automatic	Z000001 - Z196765
	4TAUN53B	4TAVL52N	Manual	Z000001 - Z197076
			Automatic	Z000001 - Z197072
	4TAVN53F	4TAVN52N	Both A/T & M/T	Z000001 - Z197100

VIN Range starting after the Model Year Indicator (S = 1995, T = 1996).

2. CHECK VEHICLE INVOLVEMENT BY FRAME NUMBER

For those vehicles produced in June or July 1996 and fall within the VIN range, check the Frame Number to determine if the vehicle is equipped with an involved Frame or an Improved Frame (NOT INVOLVED). [See Diagram 2 for Frame Number location]

Diagram 2



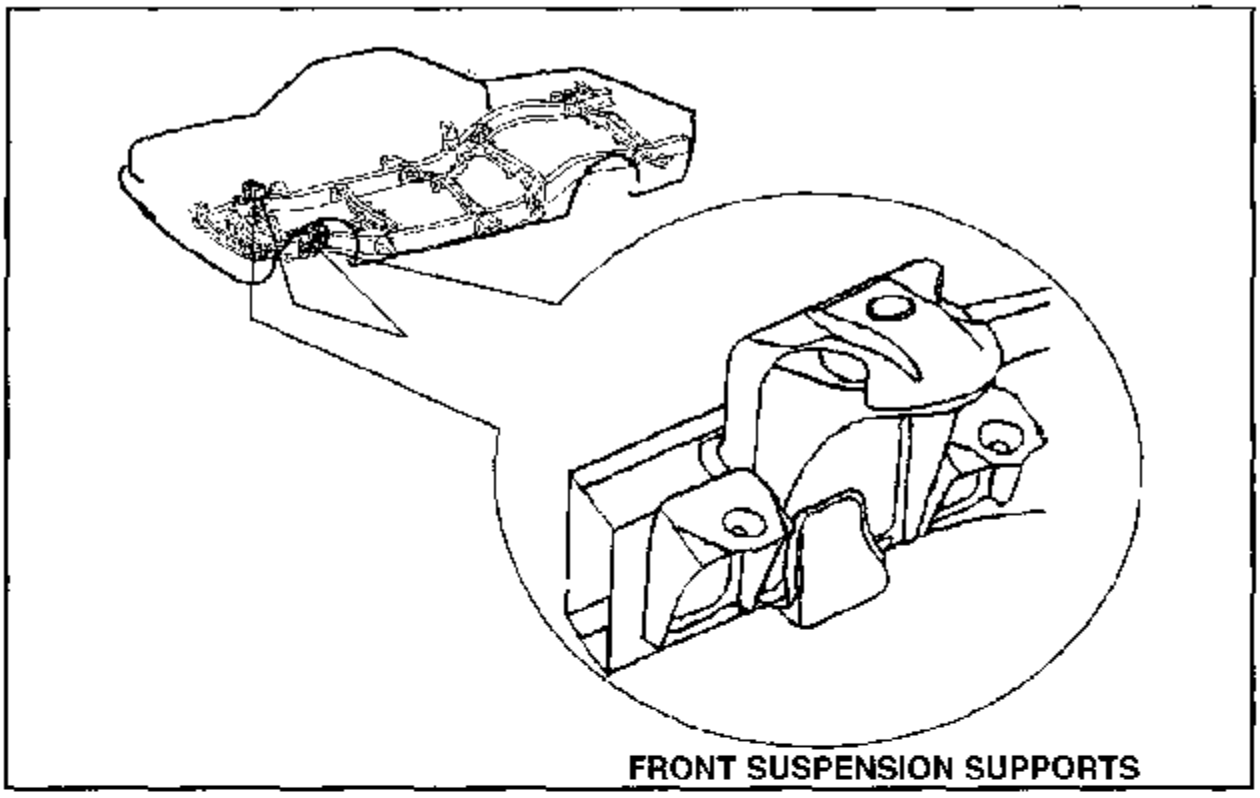
Please note the Frame Number Label is installed **upside down** on the Frame.

STARTING FRAME NUMBERS FOR IMPROVED FRAME

Model	VDS 1996	Transmission		Starting Frame No. for Improved Frame*
Tacoma 4x2	4TANL42N	Manual	A	0195396 -
		Automatic	B	
	4TAVL52N	Manual	C	
		Automatic	D	
	4TAVN52N	Both A/T & M/T	E	

*Vehicles built with these Frames and later are NOT INVOLVED in SSC T06

3. LOCATION OF INVOLVED PARTS



FRONT SUSPENSION SUPPORTS

4. PARTS REQUIRED

Part No.	Part Name	Quantity/Vehicle
04006-13135	Reinforcement Plate Kit	1 kit required per vehicle
94184-61000	Nut (stabilizer bar & shock absorber)	4 required per vehicle
95381-03220	Cotter Pin (tie-rod end)	2 required per vehicle

5. EQUIPMENT REQUIRED

Equipment Description	Use
Vehicle Hoist	Lift vehicle to perform modification procedure
General service tools	Front suspension disassembly & reassembly
Cleaning cloths/towels	Use for general cleaning
Duct Tape	Temporarily seal ABS sensor to prevent contamination
*Tie Rod End Puller SST (P/N: 09611-20015-01)	Tie rod end removal
Bungee, rope or wire	Suspend the brake caliper during operations
*Coil Spring Compressor SST (SSC Kit) (P/N: 09727-22011-ST)	Coil spring removal & reinstallation
Lubricating oil	Lubricate threads of Coil Spring SST with light oil prior to each use
Silicone Spray or Rubber Lubricant	Lubrication to ease disassembly/ reassembly of spring bumper stops
*MAGNAFLUX® Spotcheck Kit (SSC Kit)	Checking suspension support for cracks
*Suspension Support Assembly w/plates (SSC Kit)	For welding practice
Suspension Support Mounting Plate (SSC Kit)	Mount suspension support for welding practice
Bench Vise	Hold mounting plate and suspension support for welding practice
Fine-tip Permanent Marker (such as Sanford® Sharpie)	Placing alignment mark on reinforcement plates for accurate positioning
Vise Grip type pliers	Temporary reinforcement plate clamping
Gas Metal Arc Welder (GMAW) also referred to as Metal Inert Gas (MIG) welder	Reinforcement plate welding
Spatter Protector (SSC kit)	Protects the vehicle from welding spatter and grinding chips
White Marker (Soapstone)	Outline reinforcement plate location
Disk Grinder/Sander	Paint/excess material removal at weld area
Wire Brush	Cleaning of weld area
Air gun (shop air)	Cleaning of weld area
Brake Cleaner (e.g. Toyota Brake Cleaner P/N: 00289-2BC00)	Degreasing of Suspension Support & Reinforcement Plates prior to welding
*3M® Weld-thru Coating (one can in SSC Kit) (3M® P/N: 051131-05913)	Corrosion protection between welded surfaces
*Chassis Paint: Rustoleum® Hard Hat Black Top Coat (2179) Rustoleum® Hard Hat Red Primer(2169)	Refinishing of modified suspension support area
Torque Wrenches	Reassembly of suspension components
Wheel Alignment Equipment	Alignment check/adjustment

*** See Suppliers for additional Tools, Chemicals and Paints.**

(6) SUPPLIER LIST

EQUIPMENT	CONTACT
Tie Rod End Puller SST (P/N: 09611-20015-01)	OTC, A division of SPX Corporation 655 Eisenhower Drive, Owatonna, MN 55060 Phone: 1-800-933-8335
Coil Spring Compressor SST (P/N: 09727-22011-ST)	OTC, A division of SPX Corporation 655 Eisenhower Drive, Owatonna, MN 55060 Phone: 1-800-933-8335
*MAGNAFLUX® Spotcheck Kit (MAGNAFLUX® P/N: 01-5912-48)	See MAGNAFLUX® Authorized North American Distributors List enclosed with each kit.
3M® Weld-thru Coating (3M® P/N: 051131-05913)	Order from local body shop supply outlet or call 3M® @ 1-800-521-8180 ext. 6890 for the supplier nearest you.
Chassis Paint: Rustoleum® Hard Hat Black Top Coat (2179) Rustoleum® Hard Hat Red Primer(2169)	Available from Grainger Industrial and Commercial Equipment Supplies or call 1-800-323-3584 for the supplies nearest you.

† **Additional suspension support and reinforcement plates for practice welding, <u>if required</u>, can be obtained by calling (310) 783-5316.**

DISASSEMBLY PROCEDURE

Disassembly procedure

1. Disconnect negative (-) terminal cable from the battery.
   NOTE: Before disconnecting the battery, record the preset radio stations.

2. Raise vehicle on hoist.

3. Remove both front wheels.

4. On vehicles with ABS remove the ABS speed sensor:

   (a) Remove the four (4) clamp bolts holding the sensor harness to the upper suspension arm and steering knuckle.

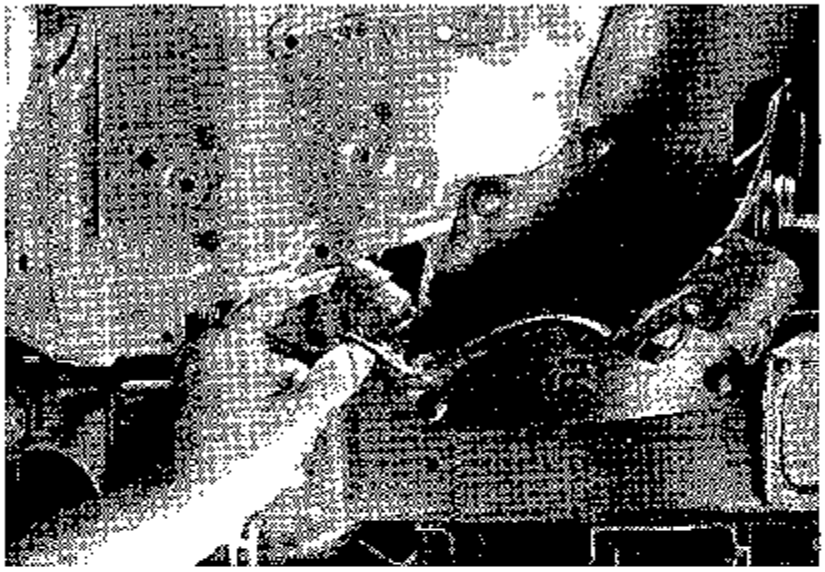
   (b) Remove the speed sensor from the steering knuckle.

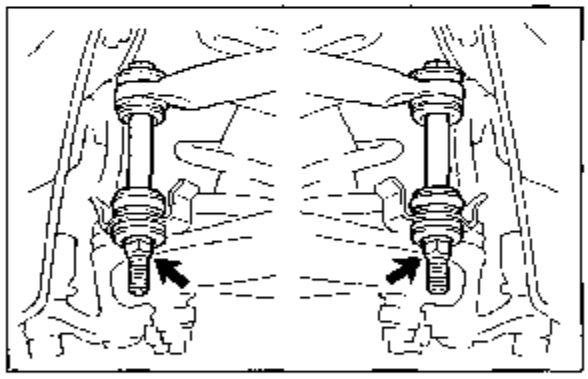
   (c) Position the sensor out of the way.
   NOTE: Using tape, seal the ABS sensor hole.

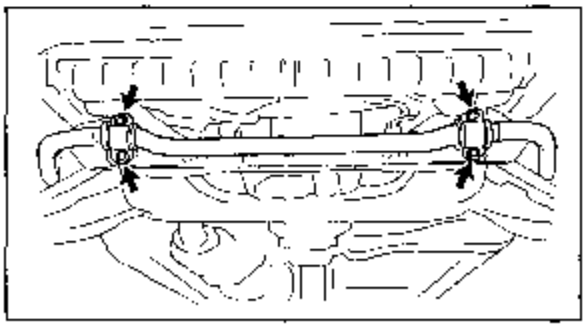
5. Remove stabilizer bar.

   (a) Hold the bolt with a wrench, then remove the two (2) nuts, retainers, collars and cushions from the lower suspension arm.

   (b) Remove the four (4) bolts and stabilizer bar with the cushions and brackets.



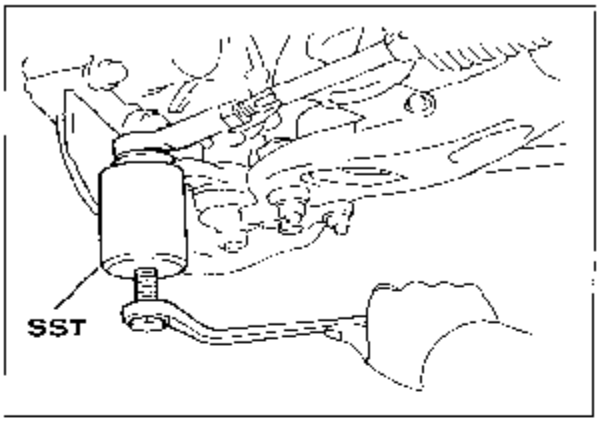




6. Disconnect tie rod end.

   (a) Remove the cotter pin and nut.

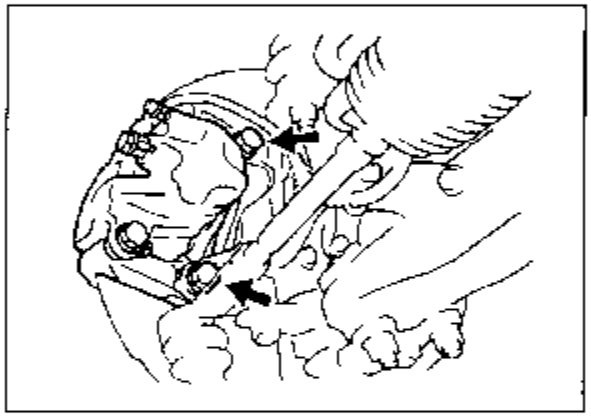
   (b) Using SST 09611-20015-01, disconnect the tie rod end.



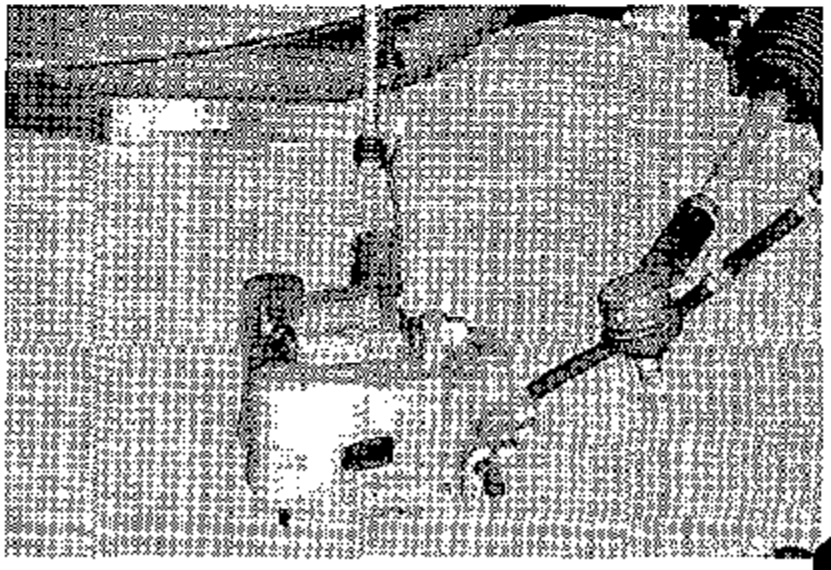
7. Brake Caliper Removal.

   (a) Remove the two (2) bolts which hold the brake hose clamps on the lower suspension arm.

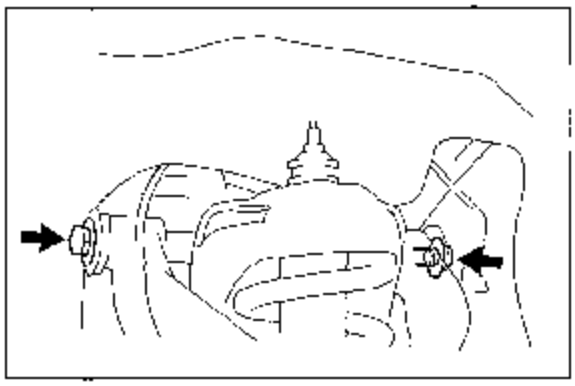
   (b) Remove the two (2) bolts and brake caliper.



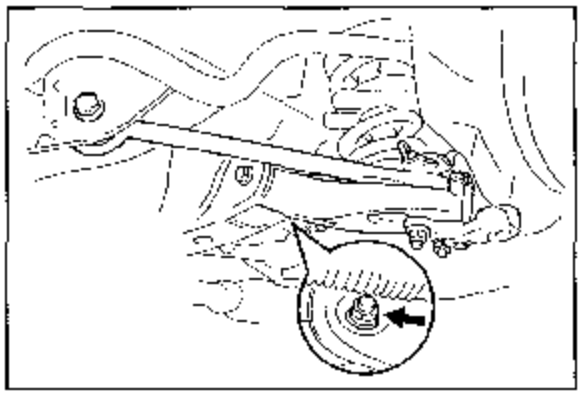
   (c) Lift off the caliper with hose still attached, secure the caliper to the frame using wires.



8. Loosen but do not remove the two (2) upper suspension arm pivot bolts.

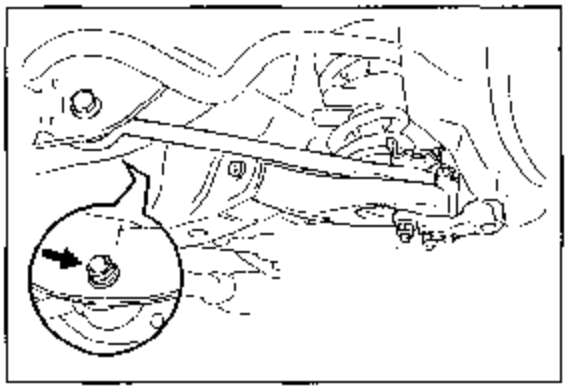


9. Loosen but do not remove the one (1) lower suspension arm pivot bolt.

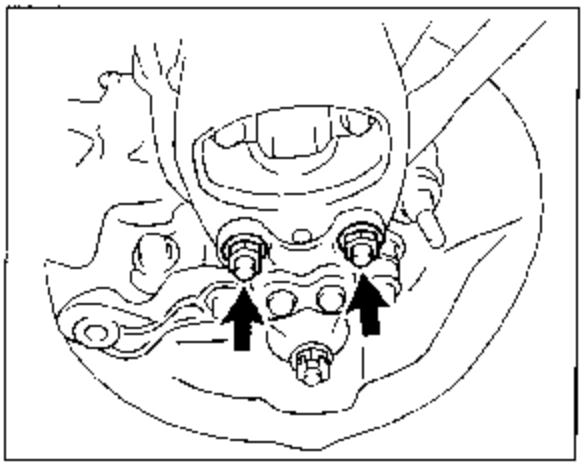


10. Remove the strut bar pivot bolts and nuts.

    (a) Remove the strut bar front pivot bolt.

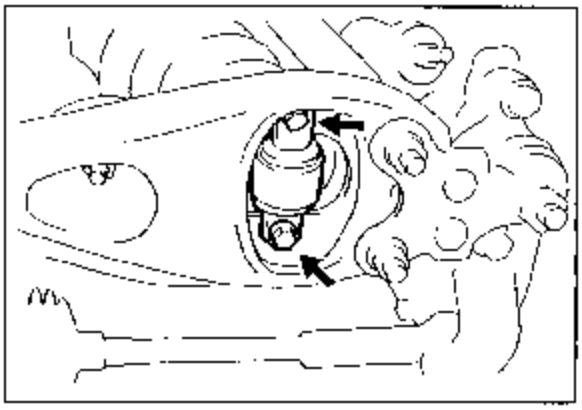


(b) Remove the two (2) strut bar mounting nuts from the lower suspension arm.

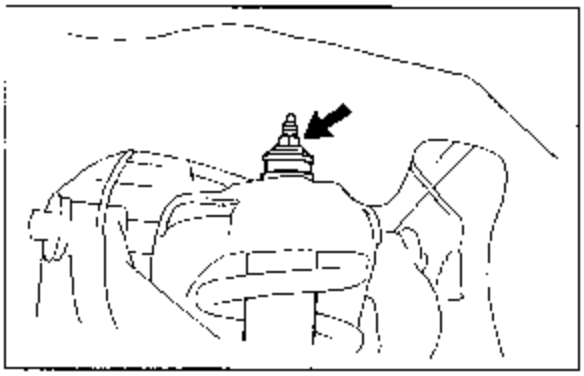


11. Remove shock absorber.

(a) Remove the two (2) bolts that fasten the shock absorber to the lower suspension arm.

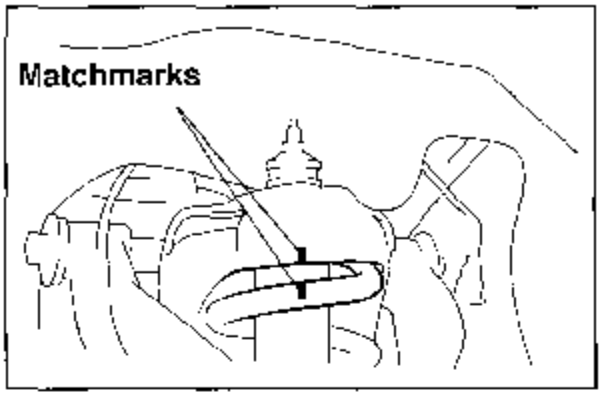


(b) Hold the end of the shock absorber rod, then remove the top nut, retainer, cushion & shock absorber.



12. Compress coil spring.

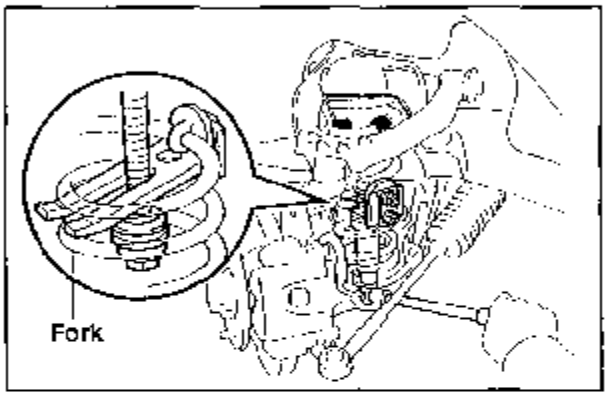
(a) Before compressing the spring, mark the spring orientation on the spring and suspension support, this will enable easier re-assembly.



(b) Using Special Tool (SST 09727-22011-ST) compress the coil spring. Position spring compressor to compress as many coil as possible.

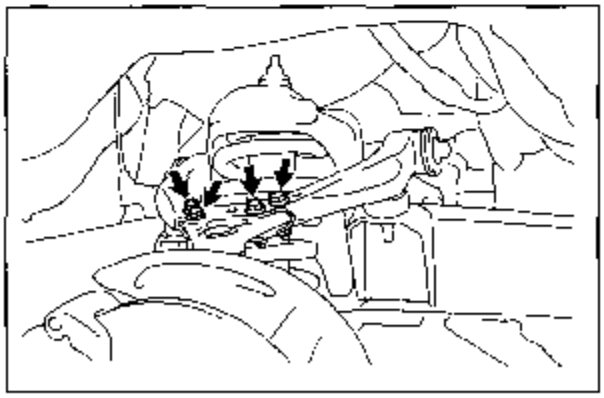
NOTE: Use caution to avoid bottoming out threaded rod on the top of suspension support.

NOTE: Lubricate the threads of the SST with light oil prior to each use.



(c) Compress coil spring until there is a clearance from both the upper spring mount and the lower suspension arm.

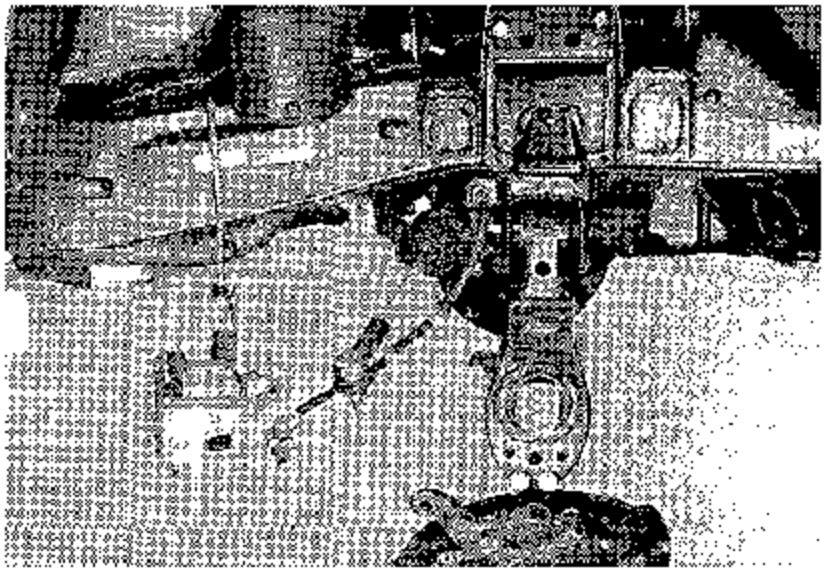
13. Remove the four (4) nuts and bolts that fasten the upper ball joint to the upper suspension arm.



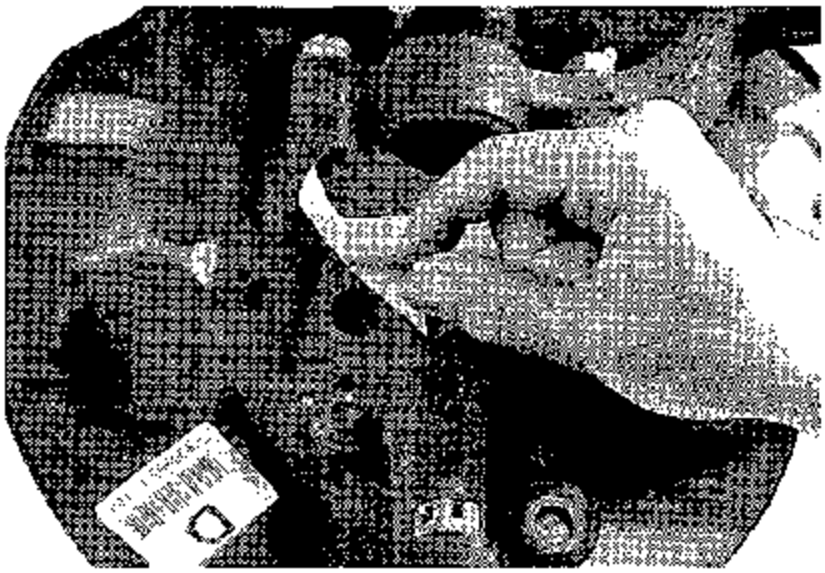
14. (a) Pull the upper ball joint mounting out of the upper suspension arm. Carefully lower the steering knuckle and hub & rotor assembly and let them hang by the lower suspension pivot bolt.

    (b) Lift the coil spring out and set it aside with SST still compressed.

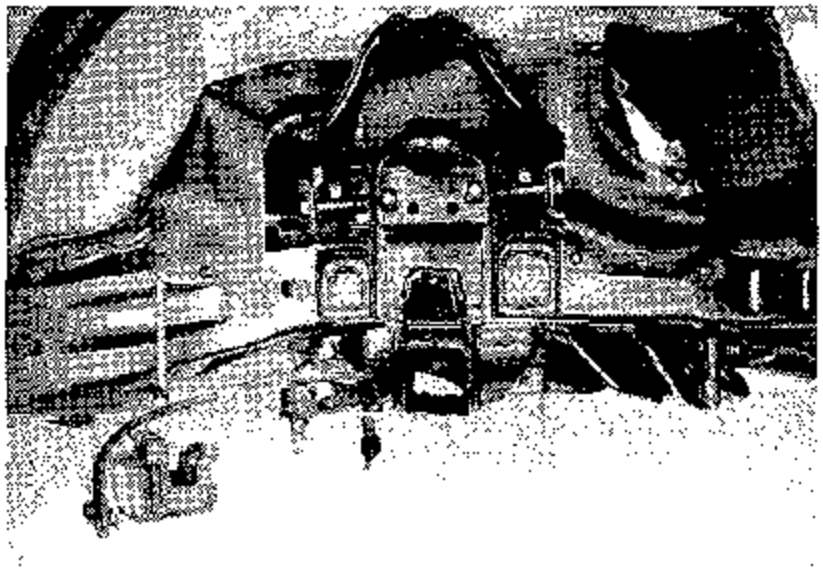
    (c) Remove the strut bar completely from the lower suspension arm.



15. Use tape to seal the ABS sensor hole (if equipped) to prevent any dirt, metal shavings or weld spatter from entering, they could interfere with the sensor function.

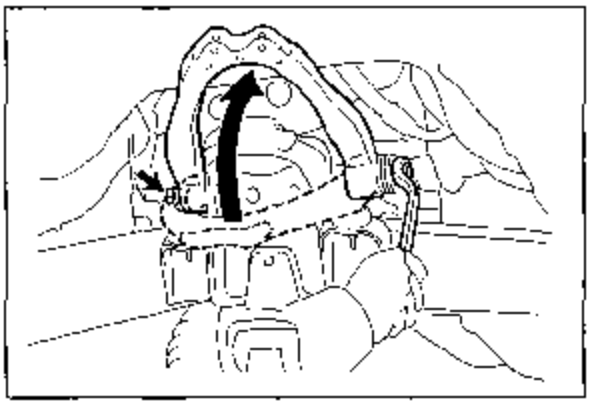


16. Remove the lower suspension arm pivot bolt and the lower suspension arm with steering knuckle and hub & rotor assembly.



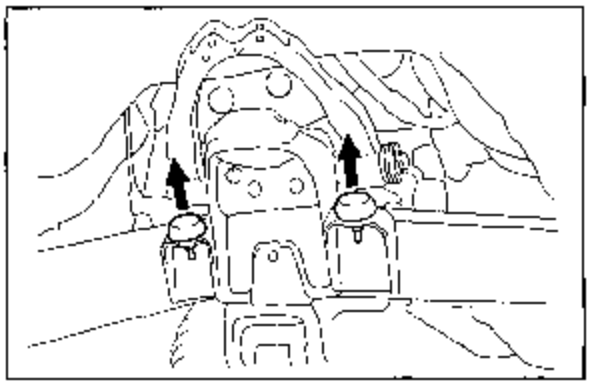
NOTE: Place all removed parts well away from the front suspension area of the vehicle to avoid the metal particles and weld spatter associated with the cleaning, welding and refinishing operations.

17. Lift the loosened upper suspension arm and tighten one (1) of the upper suspension arm pivot bolts to hold the arm up and allow for an easier working area.



18. Remove the two (2) spring bumper stops.

NOTE: Silicone spray will permit easier removal of the bumper stops.



19. Repeat procedures 4 - 18 for the other side of the vehicle.

NOTE: Use caution when removing the Spring Compressor SST from the compressed spring in order to use it for the coil spring on the other side.

DYE CHECK PROCEDURE

3

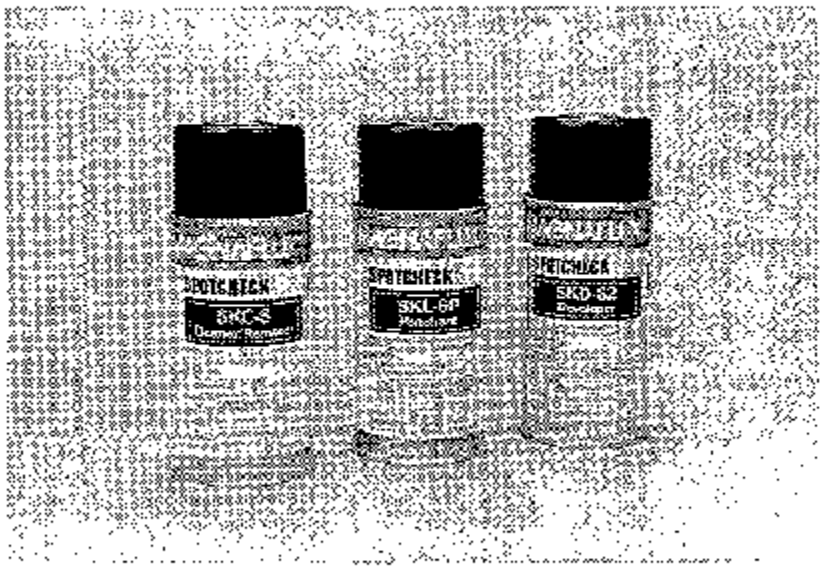
Dye Check Procedures (NOT APPLICABLE TO NEW UNUSED VEHICLES)

NOTE: If not familiar with the MAGNAFLUX® Spotcheck dye penetrant methods, please review the materials provided with the Spotcheck kit.

The Spotcheck kit includes three (3) types of materials in aerosol cans:

SKC-S Spotcheck Cleaner
SKL-SP Spotcheck Penetrant
SKD-S2 Spotcheck Developer

Be sure to use them according to the following procedure.



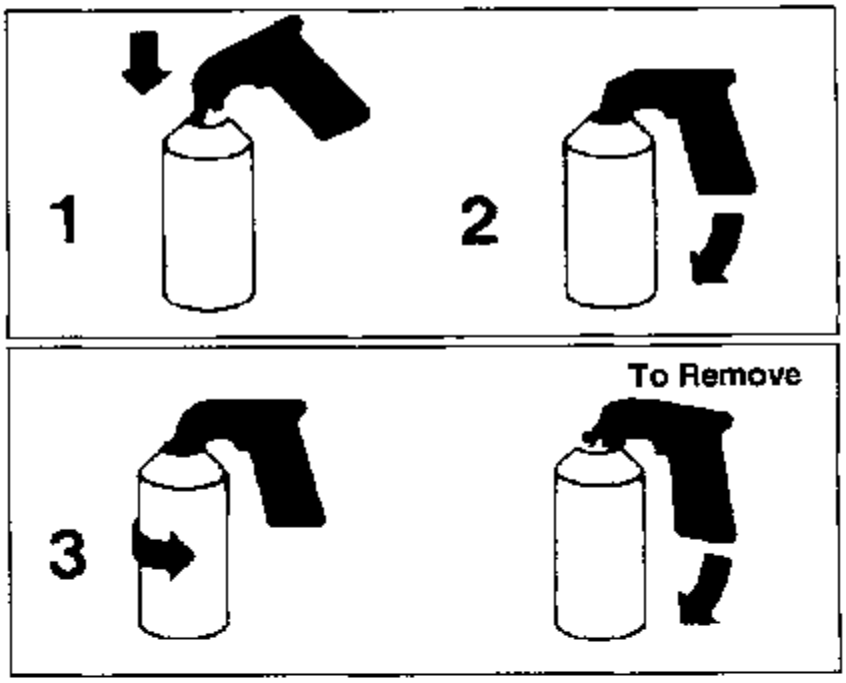
1. Utilize the "Aerosol Can Gun" included in the Spotcheck kit.

   To use:

   (1) Locate nose of "Can Gun" down inside top recessed ring of aerosol can.

   (2) Press down on pistol grip until "Can Gun" clips onto aerosol can.

   (3) Rotate aerosol can so the nozzle points forward.



2. Clean area

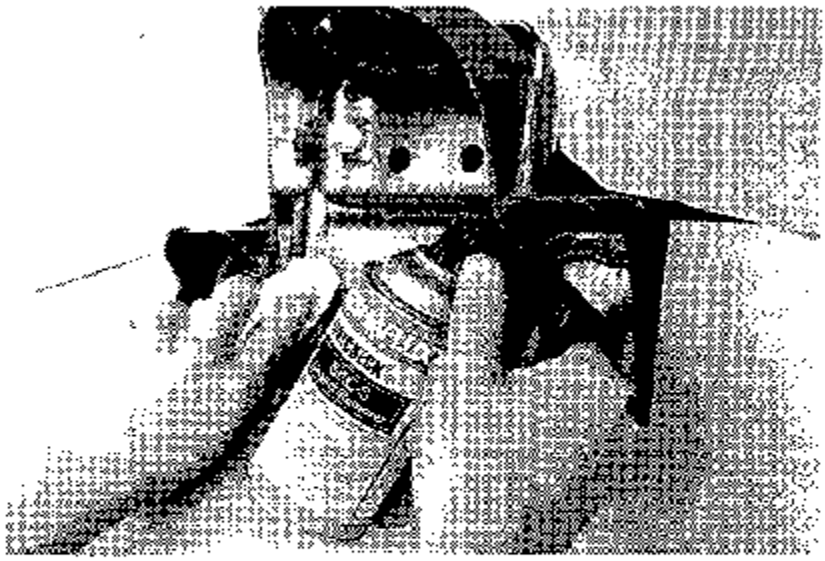
   (a) Coat the suspension support as shown with the can labeled CLEANER/REMOVER.

   (b) Allow cleaner to remain on the part long enough to dissolve dirt or film.

   (c) Wipe dry with clean cloth.

   (d) Repeat if necessary.

   (e) After final cleaning, allow ample time to dry before performing the next step.



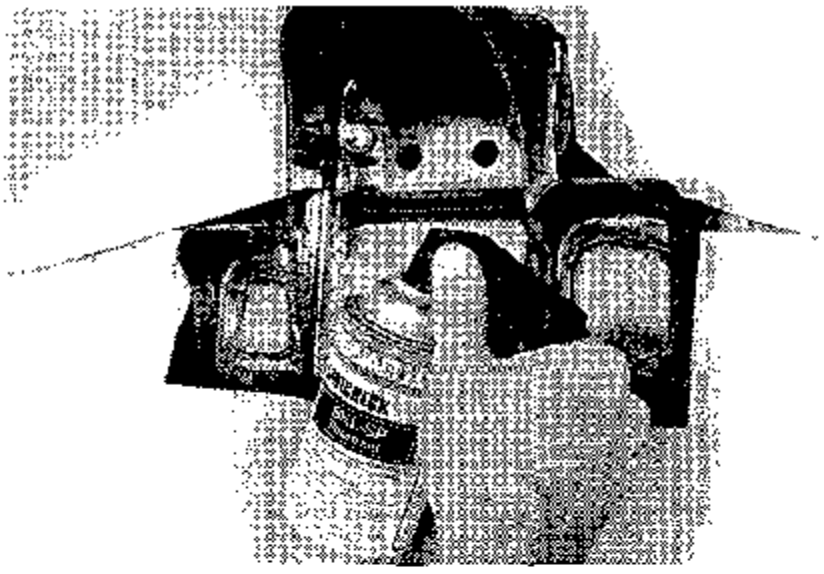
3. Apply Penetrant

   (a) Spray the suspension support as shown with the can labeled PENETRANT until the surface is covered.

   (b) If the penetrant pulls back in droplets, go back to step 2 and perform the cleaning procedure again.

   (c) Allow the penetrant to remain on the part for about 10 minutes.

   (d) Wipe the suspension support with a clean towel or cloth.

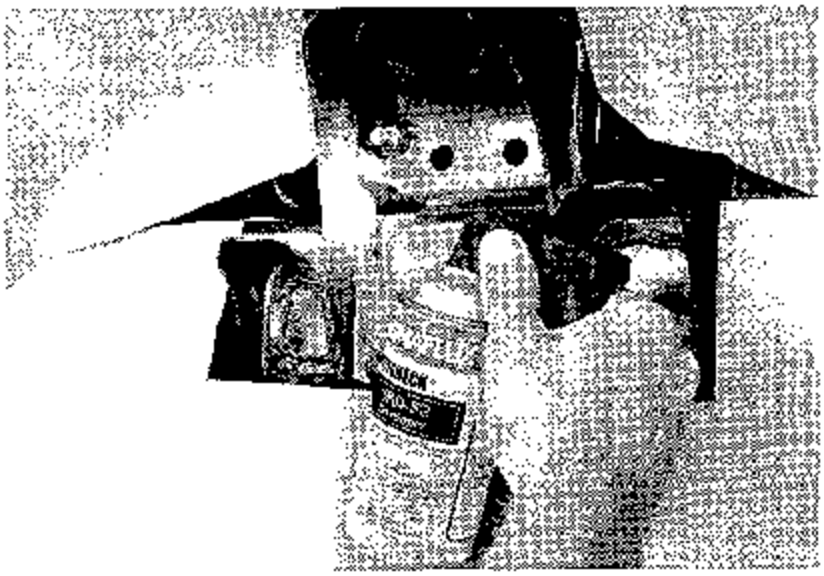


4. Develop Spotcheck Penetrant

   NOTE: Shake the aerosol can vigorously until the agitators rattle inside the can.

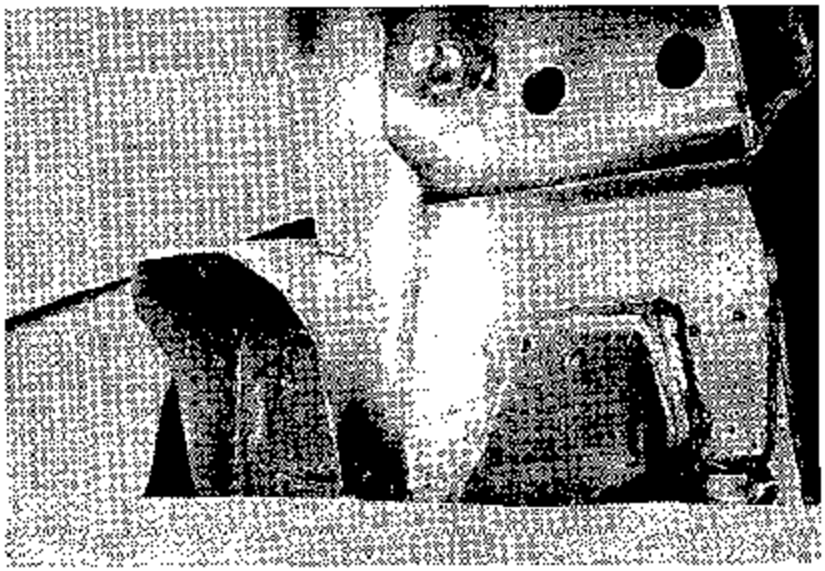
   (a) Spray the suspension support as shown with the can labeled DEVELOPER. Use just enough spray to wet the surface thinly and evenly.

   (b) Allow developer to dry.



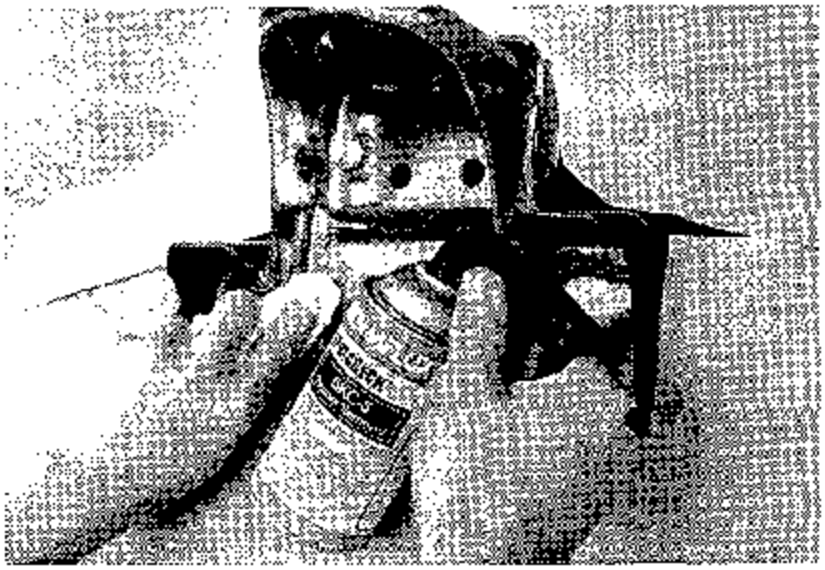
5. Inspect for cracks

   Cracks will be marked by a deep red indicator mark.



6. Clean off Spotcheck indicator dye.

   Spray the suspension support area as shown with the can labeled CLEANER/REMOVER and wipe with a clean cloth until all traces of the Spotcheck indicator is removed.



SELECTING WELDING TECHNICIANS

TOYOTA

SELECTING WELDING TECHNICIANS

For special service campaign TO6 (Tacoma 4x2 Front Suspension Support), an important part of the modification procedure is selecting a qualified welding technician to install the reinforcement plates. To assist in this process, the following will apply:

- As a first step, identify companies in your area who provide on-site welding services. This can most easily be accomplished by consulting the Yellow Pages of the telephone book under the heading of Welding.

- To determine welding service companies' ability to perform the required welding, it is necessary to confirm that they have available a gas metal arc welder (GMAW), often referred to as a metal inert gas (MIG) welder. The equipment must be portable and capable of operating without external power supply as not all dealers will have an appropriate electrical supply outlet at the required location.

- Advise the welding company that a complete Welding Procedure Specification will be provided and that the welding technician must be proficient (preferably certified) in the use of GMAW/MIG welding equipment. Ideally with a minimum of three years experience.

  NOTE: Several welder certification procedures exist in the United States. They are for different types of welding equipment and for different types of welding jobs (e.g., structural, marine, aircraft, steam plant, etc.). It is accepted practice that a welding technician demonstrate his ability to perform the specific job. Advise them that they will be required to weld a sample test part to confirm their ability to perform the necessary work.

- Before the welding technician performs the welding practice provide him with a copy of the Toyota Welding Procedure Specification for SSC TO6.

- Following completion of the practice welding, confirm with the welder that he is confident of his ability to perform the required modification on the actual vehicles.

NOTE: If you are concerned about making a determination as to the weld quality you may send the test welded suspension support to Toyota Motor Sales (TMS) for evaluation by an independent testing facility. Before sending the suspension support to TMS, fill out the Welder and Welding Technician Qualification Test Record, insert this completed form into the plastic zip-lock bag provided and attach it to the test welded suspension support.

Package the suspension support in the box provided in the SSC Kit. Attach the prepaid UPS 2nd day shipping label, also included in the SSC Kit, and ship the part to the Toyota Motor Sales, Inc., Parts Recovery Center.

A timely evaluation of the weld will be performed and immediate results provided to the sender.

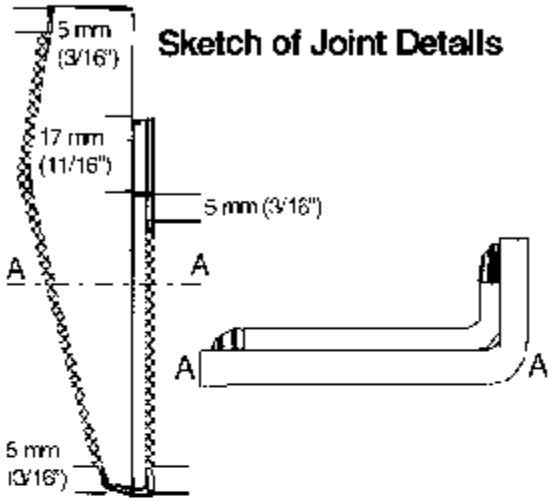
WELDING PROCEDURE SPECIFICATION

Welding Procedure Specification No.: *Toyota SSC T06*
Welding Process: *GMAW (MIG)* Type: *Semi-Automatic*
Mode of Transfer for GMAW: *Short Circuit Transfer*

JOINTS

Type of Welded Joint: *Lap Fillet*
Backing: *Yes*
Backing Material Type: *Material of Weld Joint*
Fillet Weld
one side: _____ both sides: *Yes*

Sketch of Joint Details



BASE METAL

Material specification type and grade:
Sheet steel: *AISI/SAE 1029* to *AISI/SAE 1045*
Thickness Ranges:
Sheet steel: *.125" - .135"*
Base Metal Preparation: *Remove paint. Clean all surfaces & prime with 3M® Weld-thru Coating 3M® Part # 051131-05913*

FILLER METAL

Specification: *AWS A5•18*
Classification: *ER 70S-3*

POSITION

Position of Groove: *N/A*
Position of Fillet: *Vertical*
Progression: *Down*

PREHEAT

Preheat Temperature Min: **50°F*
Preheat Temperature Max: *N/A Single Pass*
**If temperature of frame is below 50°F the vehicle must be kept in a heated shop until temperature is >50°.*

GAS

Shielding Gas: *Argon + CO_2* Flow Rate: *30 - 40 cu.ft/hr.*
Percent Mixture: *Argon 75%, CO_2 25%*
Cup Diameter: *5/8" (Cup should be even with contact tip and must be kept clean and protected with anti-spatter compound.)*

TECHNIQUE

Pass No.	Electrode Size	Welding Current		Travel Speed	Wire Stick-out	Wire Feed Speed**
		Amperes	Volts			
1	.035" (.9mm)	135 - 150	19 - 20	12 IPM	1/2" Max	200 - 220 IPM

** Run wire for 5 seconds, measure length in inches, multiply by 12 = IPM.

TOYOTA

WELDER AND WELDING TECHNICIAN QUALIFICATION TEST RECORD

Fill in all blank areas.

In accordance with welding procedure specification No.: *Toyota SSC TO6*

Welding Process *GMAW (MIG)* Type: *Semi-Automatic*

Mode of Transfer for GMAW: *Short Circuit Transfer*

Make and Model Number of Welder: _____

Electrode: _____ Amperes: _____ Volts: _____

Shielding Gas: _____ Cup Dia.: _____ Wire Stickout: _____

Wire Feed Speed: _____ Travel Speed: _____

Side A

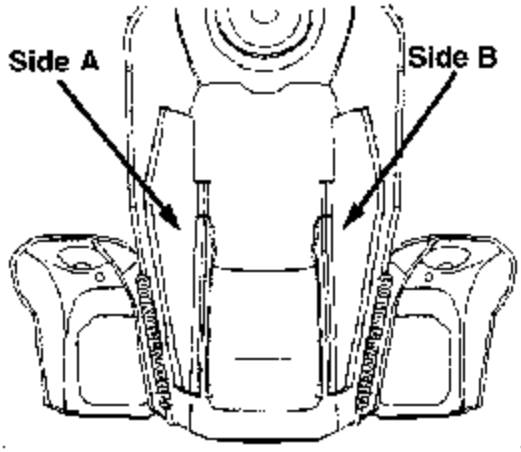
Welding Company: _____

Welding Technician's Name: _____

Identification No.: _____

Qualification Date: _____

Welding Technician Social Security No.: _____



Side B

Welding Company: _____

Welding Technician's Name: _____

Identification No.: _____

Qualification Date: _____

Welding Technician Social Security No.: _____

Dealer Name:		**Dealer Code:**
Contact Name:		
Shipping Address:		
Telephone No.:		

VISUAL EXAMINATION RESULTS *(TO BE COMPLETED BY TESTING LABORATORY)*

Side A: _____ Side B: _____

Appearance: *A.* *B.* Cracks: *A.* *B.* Undercut: *A.* *B.*

Reinforcement: *A.* *B.* Other: *A.* *B.*

Test Conducted By: _____ Per: _____

Laboratory Test No.: _____ Date of Test: _____

5

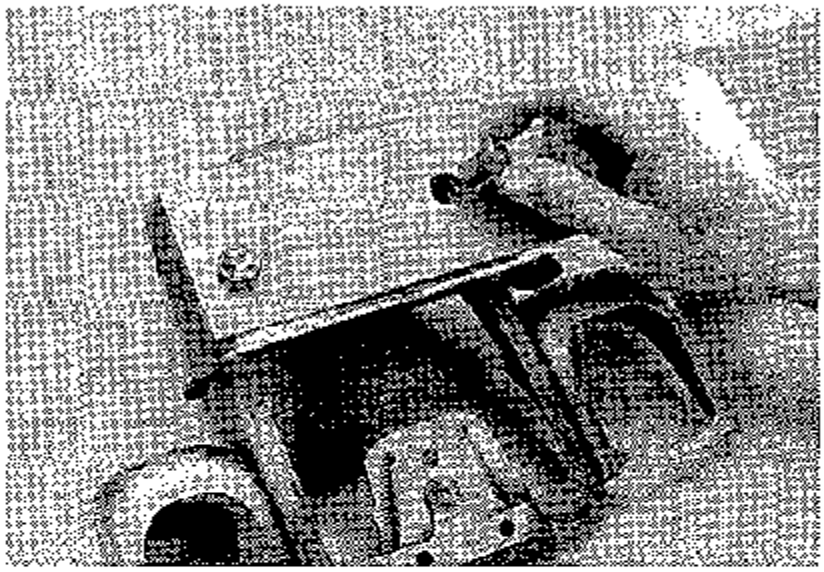
WELDING PRACTICE

Welding Practice

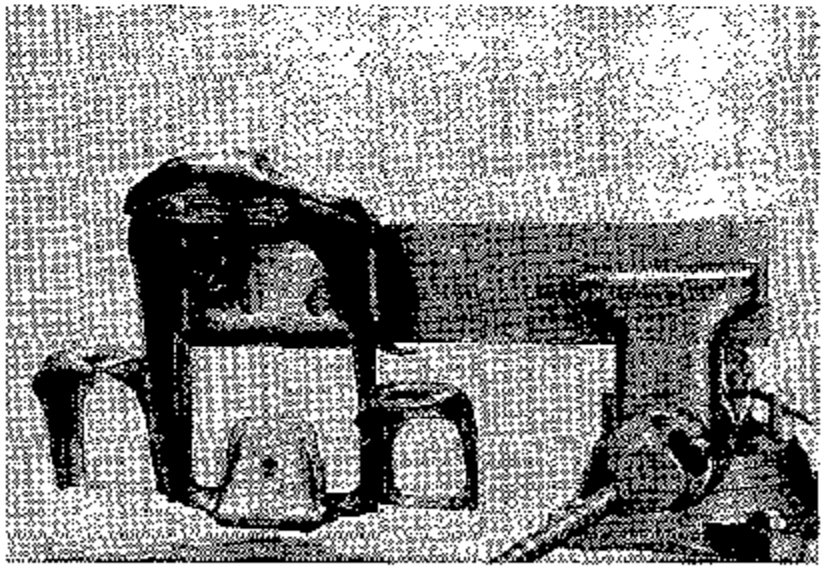
NOTE: THIS PORTION SHOULD BE PERFORMED TO CONFIRM PROPER SETUP OF WELDING EQUIPMENT AND FAMILIARIZE THE WELDER WITH THE TECHNIQUES REQUIRED TO ACCOMPLISH THIS JOB.

Welding specifications:
Refer to **Welding Procedure Specification** in the **Selecting Welding Technicians** section.

1. Bolt the suspension support assembly to the mounting plate.



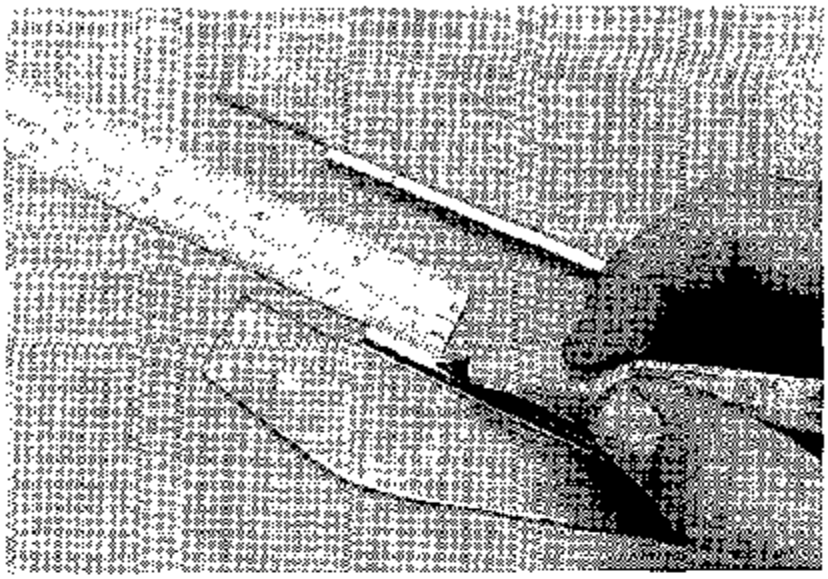
2. Clamp the mounting plate in a vise as shown.



3. Place location mark on reinforcement plates.

   (a) Use a fine-tip permanent marker (such as Sanford® Sharpie).

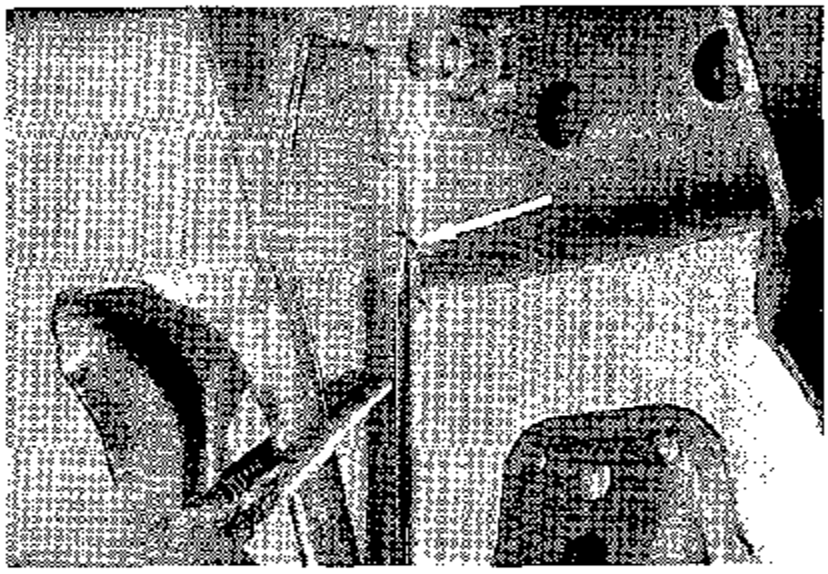
   (b) Locate mark 17mm (0.67 in.) below the shoulder as shown.



4. To determine the area to be cleaned and primed temporarily position reinforcement plates into proper position on the suspension support.

   Align matching mark with the suspension support location as shown.

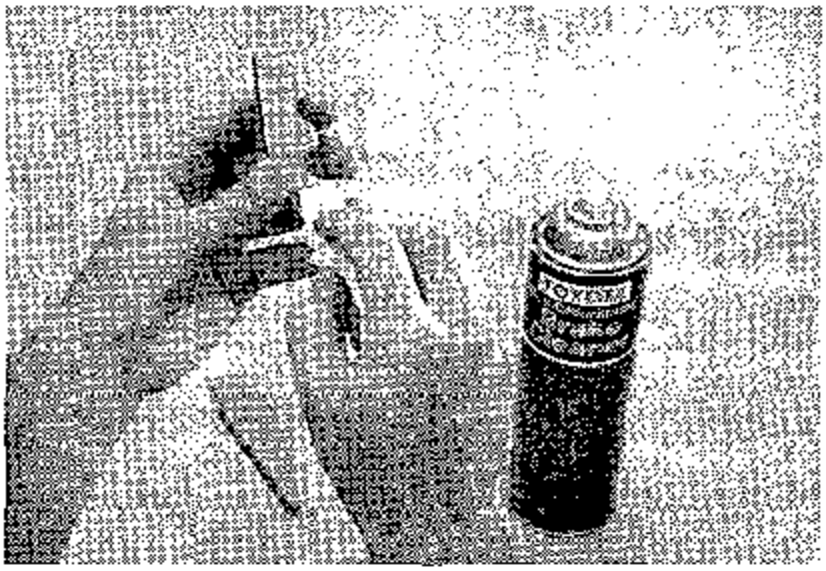
   NOTE: Remove any weld spatter from original factory welding that would interfere with correct fit of reinforcement plates



5. Remove reinforcement plate and use Toyota Non-Chlorinated Brake Cleaner (P/N: 00289-2BC00) to degrease:

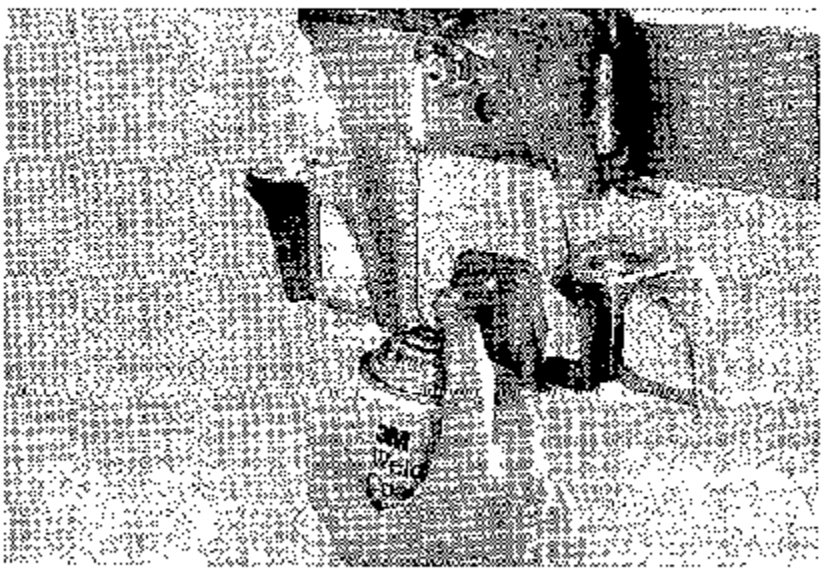
   (a) The front suspension support sides,

   (b) and both sides of the reinforcement plates to prepare for welding.



6. Using 3M® Weld-thru Coating (3M® P/N: 051131-05913):

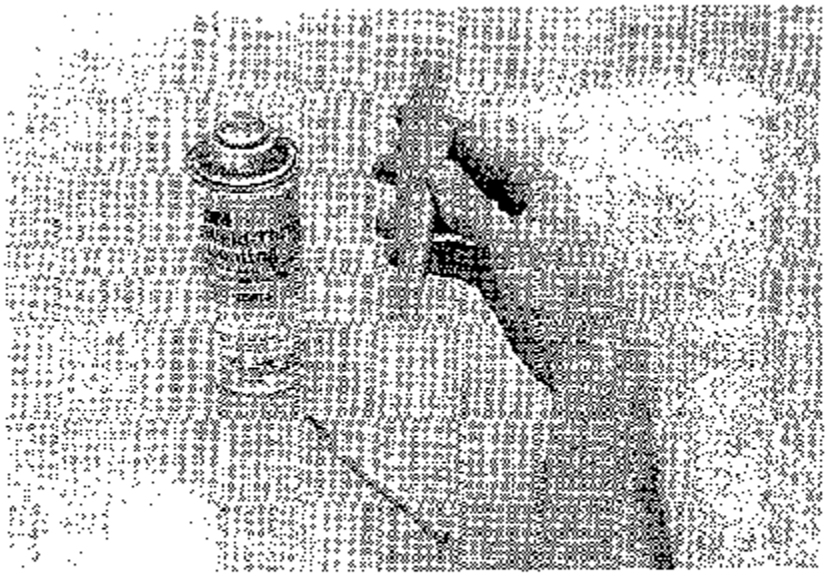
   (a) Spray the weld area,



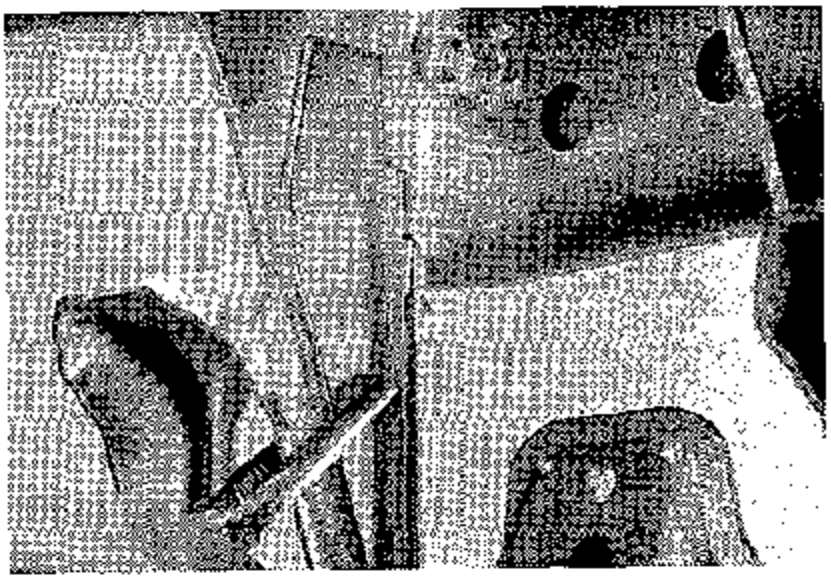
(b) as well as the back of the reinforcement plates to prevent corrosion between weld surfaces.

NOTE: Follow directions on the can for correct use and precautions.

NOTE: It is important to shake the can well before each spray.

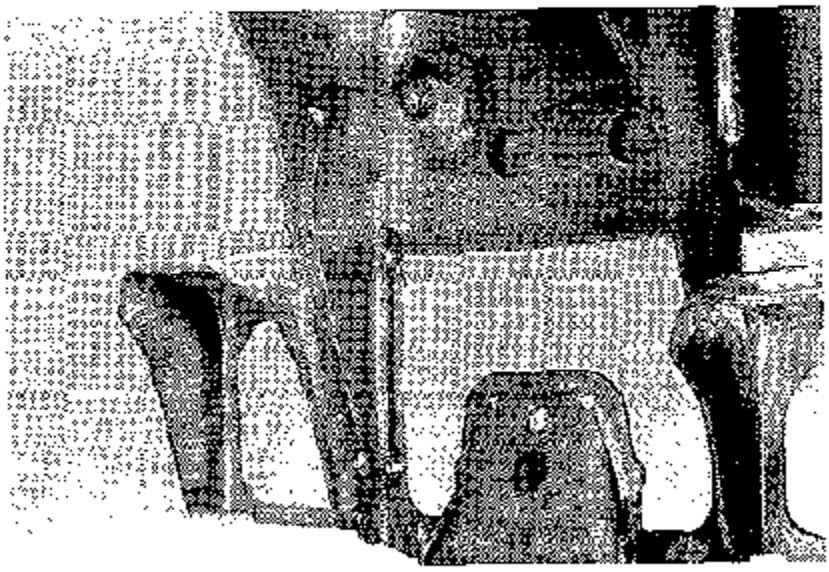


7. Utilizing a vise grip, clamp the reinforcement plate onto the front suspension support, be sure to align the positioning mark correctly.



8. Tack weld the reinforcement plate at the four (4) locations shown. Tack welds must be 3/16 in. (5 mm) from the end of the reinforcement plate or suspension support flange as applicable.

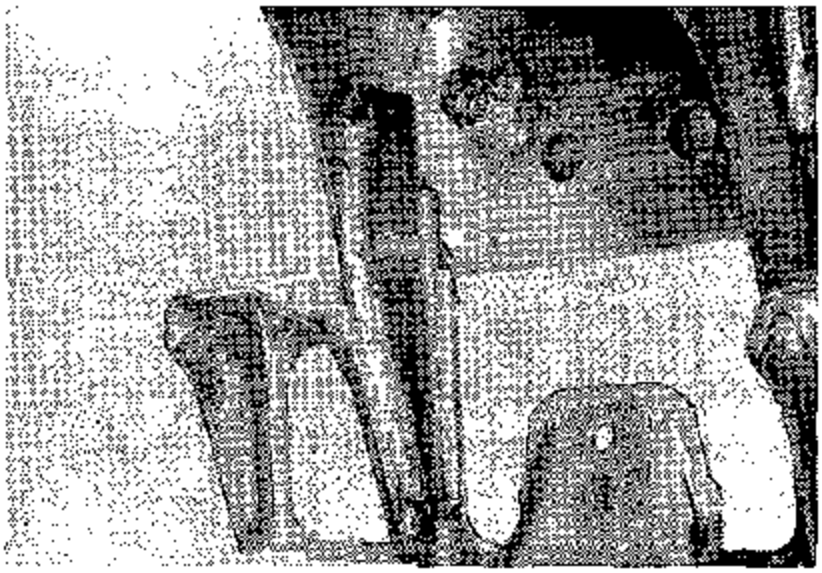
   When the reinforcement plate is securely tacked in place, remove clamp.



9. Weld the reinforcement plates down the front and then the rear edges.

   NOTE: Weld beads must start and stop 3/16 in. (5 mm) from the end of the reinforcement plate or suspension support flange as shown.

   NOTE: Do not weld corners of plate.



10. Check weld quality.

    When a welder has confirmed the weld quality using the practice components it is permissible to proceed to the vehicle modification. It is not necessary to reconfirm weld quality using practice components each time a vehicle is modified, only when a welding technician is performing the modification for the first time. All future vehicle modifications should be performed by welding technicians who have successfully conducted the welding practice procedure.

6

WELDING REINFORCEMENT PLATES

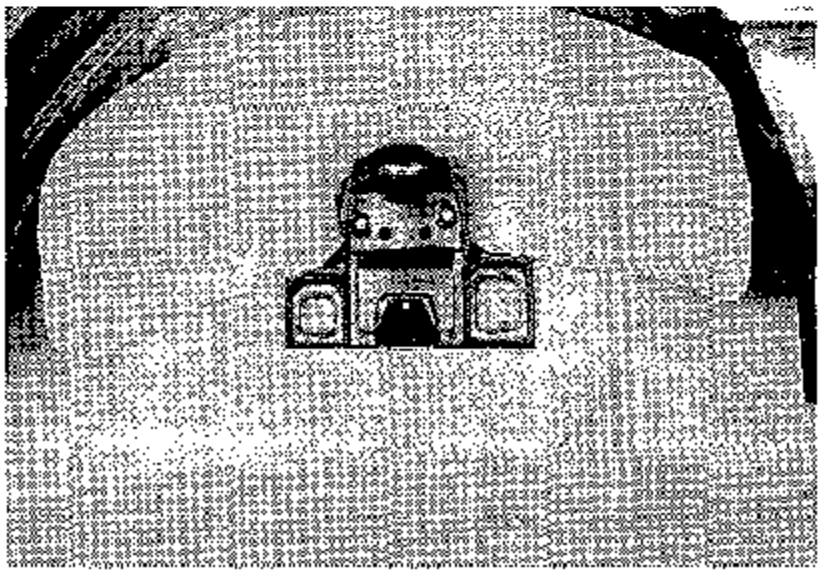
Welding Reinforcement Plates on Vehicle

NOTE: THIS PORTION SHOULD BE PERFORMED BY A CERTIFIED/PROFESSIONAL WELDER, WHO HAS SUCCESSFULLY COMPLETED THE WELDING PRACTICE.

Welding specifications:
Refer to **Welding Procedure Specification** in the **Selecting Welding Technicians** section.

1. Install spatter protector shields to protect the vehicle from welding spatter and grinding chips.

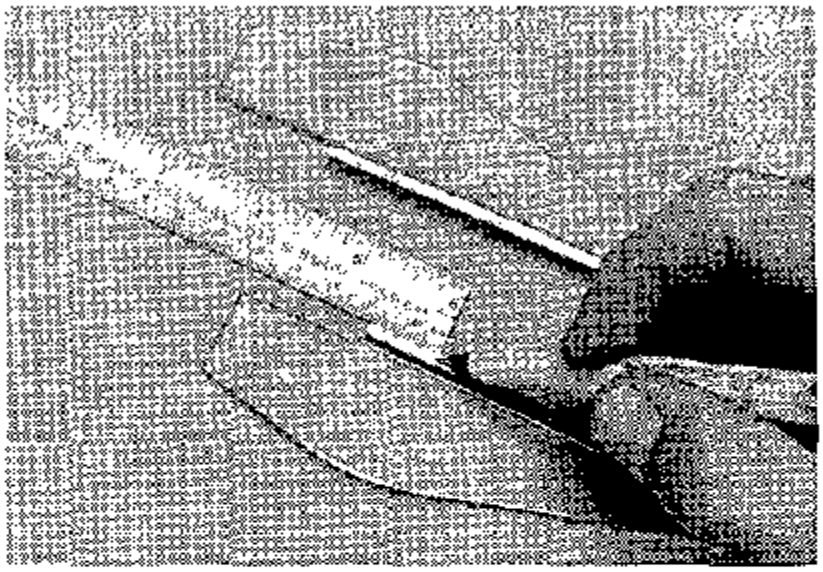
   NOTE: Do not proceed until both shields are properly installed.



2. Place location mark on reinforcement plates.

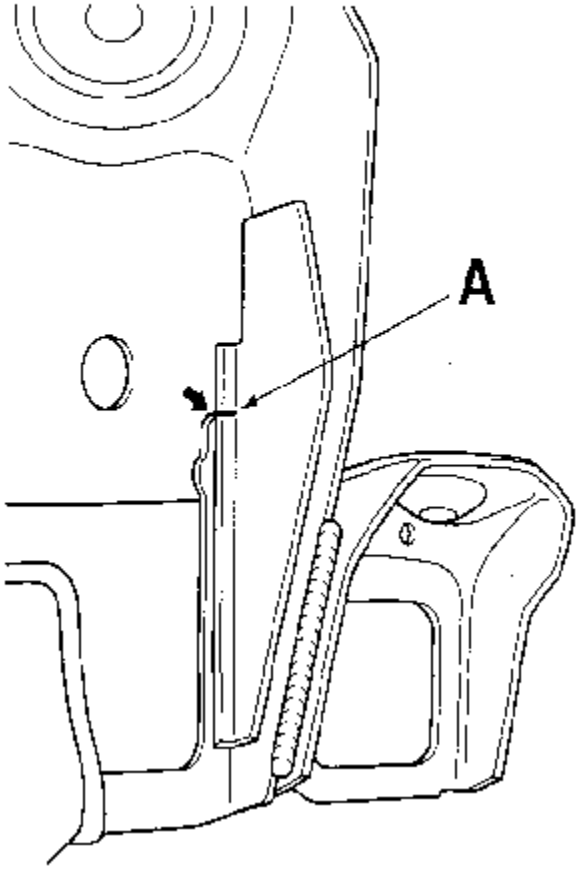
   (a) Use a fine-tip permanent marker (such as Sanford® Sharpie).

   (b) Locate mark 17mm (0.67in.) below the shoulder as shown.

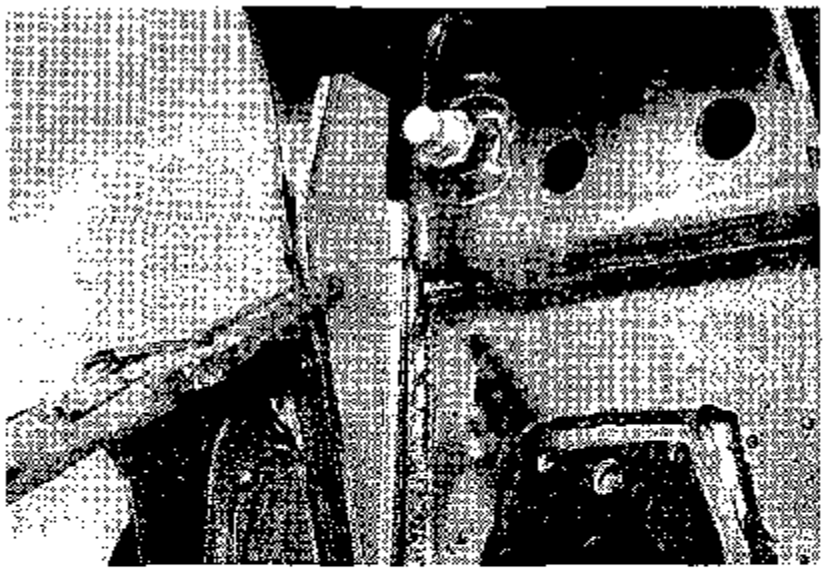


3. Position reinforcement plates into proper position on the suspension support.

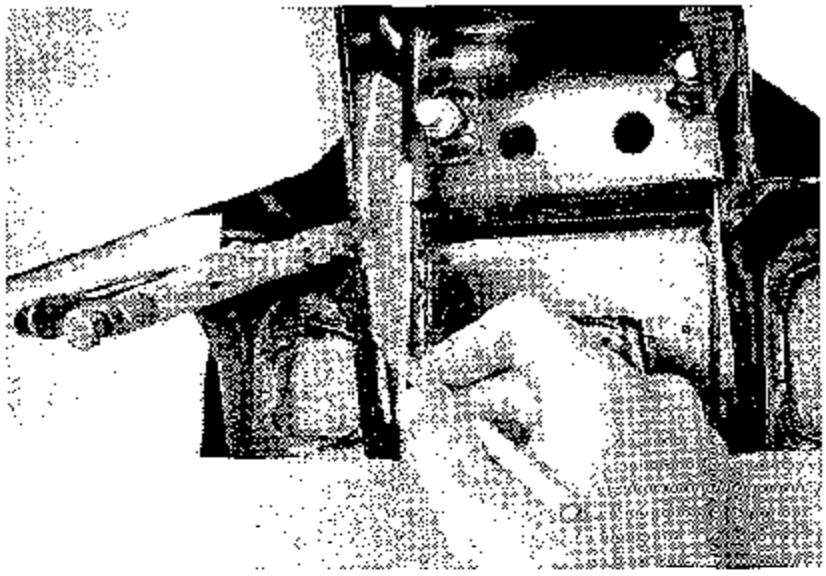
   Align matching mark with the suspension support location shown by "A" in the illustration.



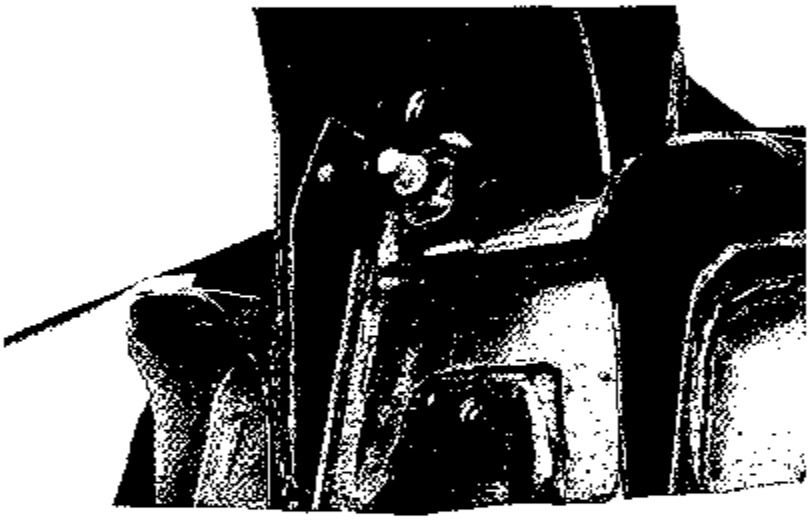
4. Clamp the reinforcement plate precisely onto the front suspension support as shown.



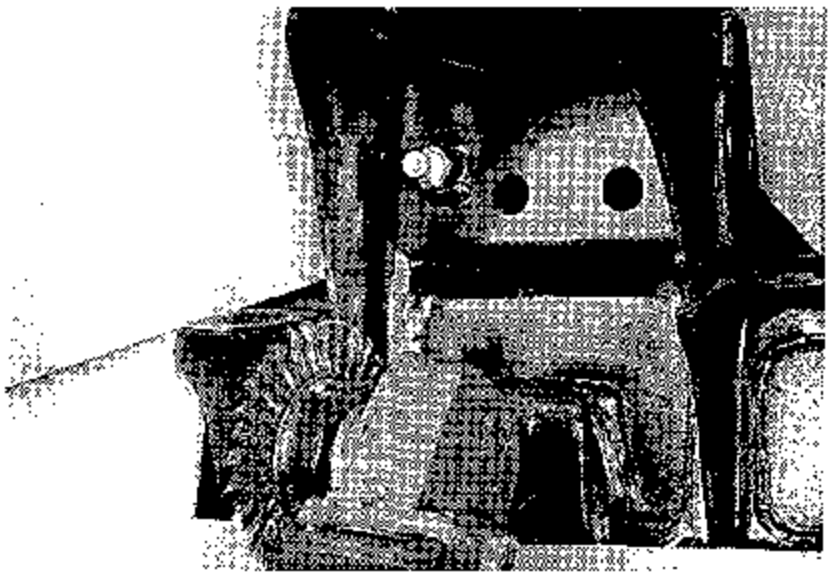
5. Use white marker to outline the reinforcement plate.



(a) Outline of plate must be clearly visible when reiforcement plate is removed.



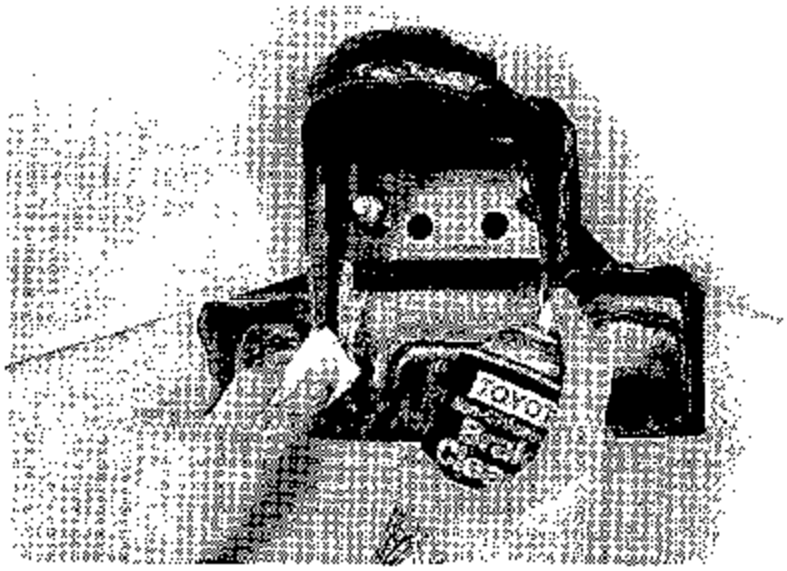
6. Sand or wire brush off the paint from the area where the welds will occur and smooth out the surface for welding.



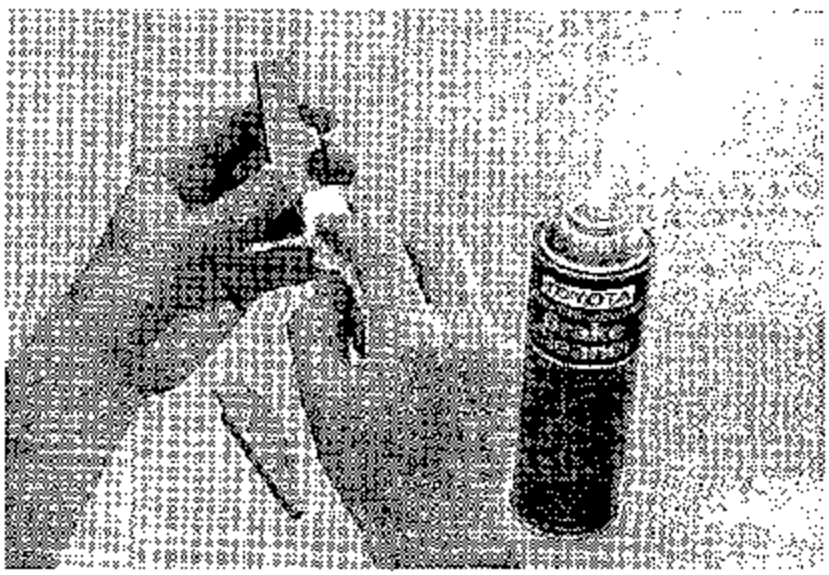
NOTE: Be sure to remove any spatter from original factory welds that would prevent the correct positioning of the reinforcement plates.

7. Use Toyota Non-Chlorinated Brake Cleaner (P/N: 00289-2BC00) to degrease:

   (a) The front suspension support sides,

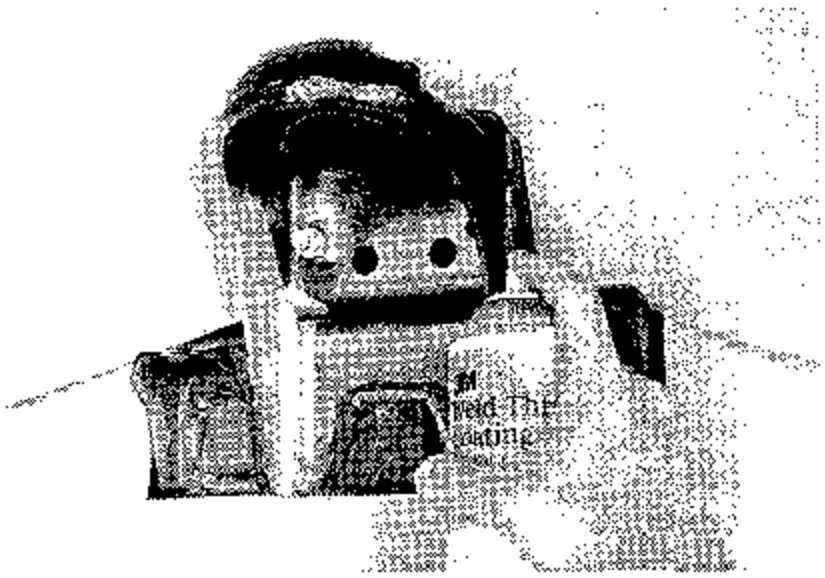


   (b) and both sides of the reinforcement plates to prepare for welding.

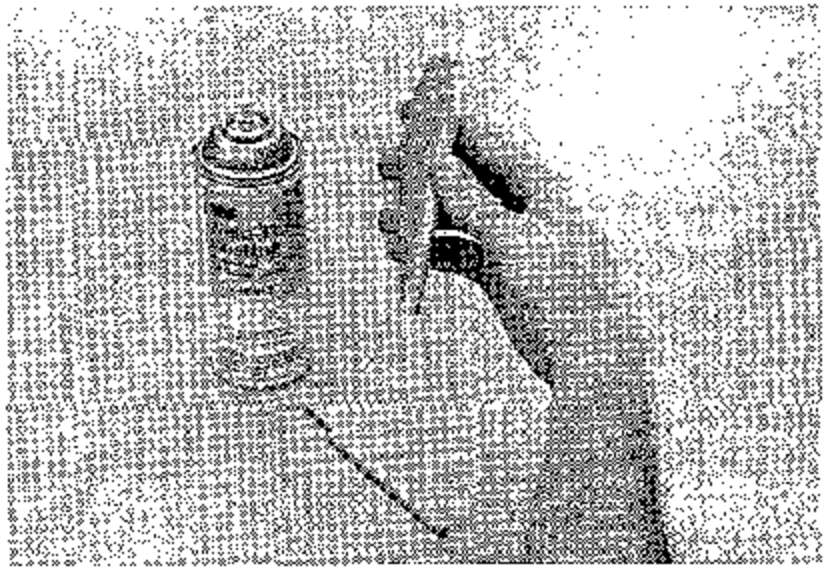


8. Using 3M® Weld-thru Coating (3M® P/N: 051131-05913):

   (a) Spray the weld area,



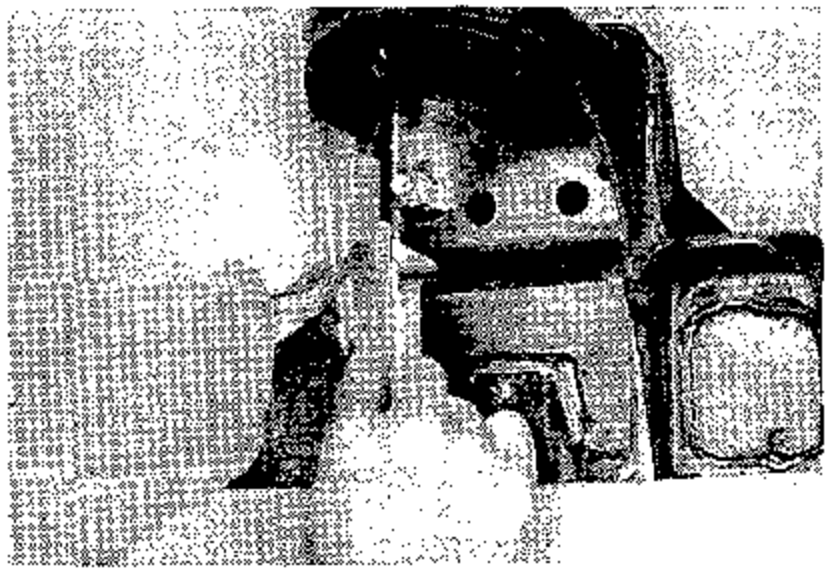
   (b) as well as the back of the reinforcement plates to prevent corrosion between weld surfaces.



   NOTE: Follow directions on the can for correct use and precautions.

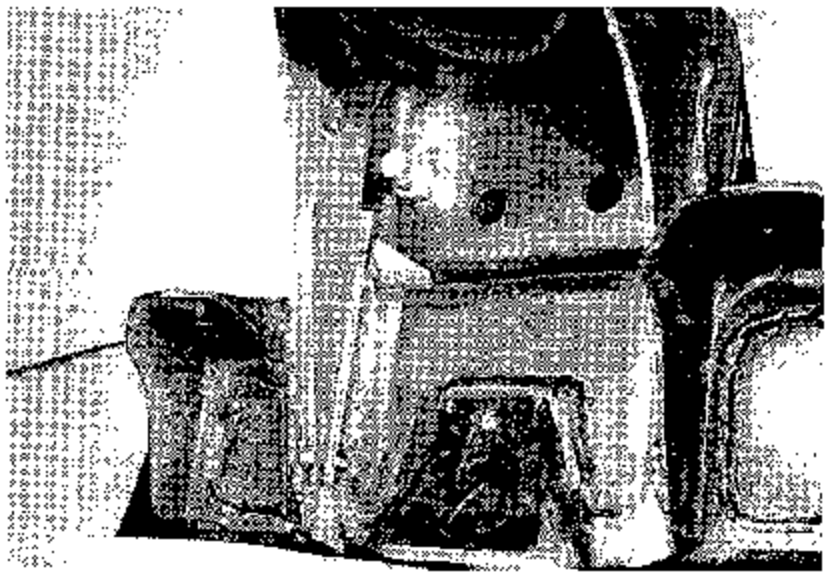
   NOTE: It is important to shake the can well before each spray.

9. Utilizing a vise grip, clamp the reinforcement plate onto the front suspension support, be sure to align the positioning mark correctly.



10. Using a GMAW/MIG Welder, tack weld the reinforcement plate at the four (4) locations shown. Tack weld must be 3/16 in. (5 mm) from the end of reinforcement plate or suspension support flange as applicable.

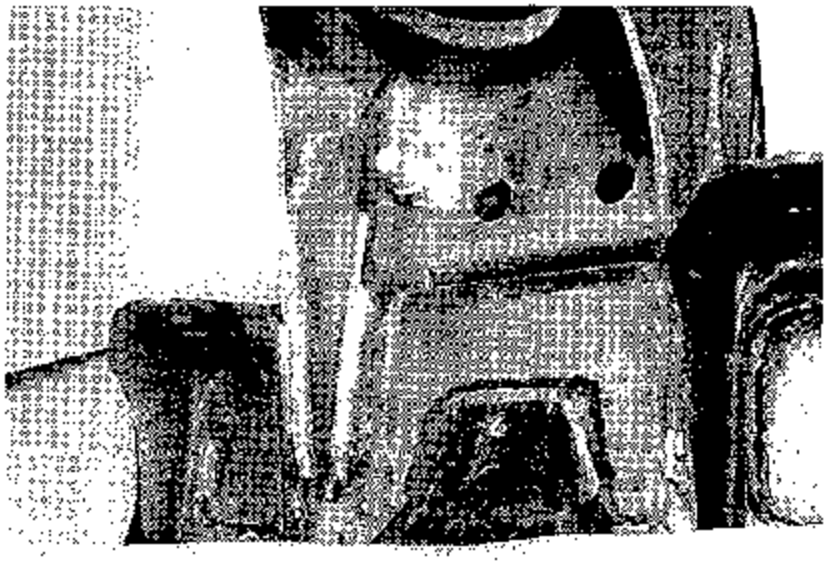
    When the reinforcement plate is securely tacked in place, remove clamp.



11. Weld the reinforcement plates down the front and then the rear edges.

    NOTE: Weld beads must start and stop 3/16 in. (5 mm) from the end of the reinforcement plate or suspension support flange as shown.

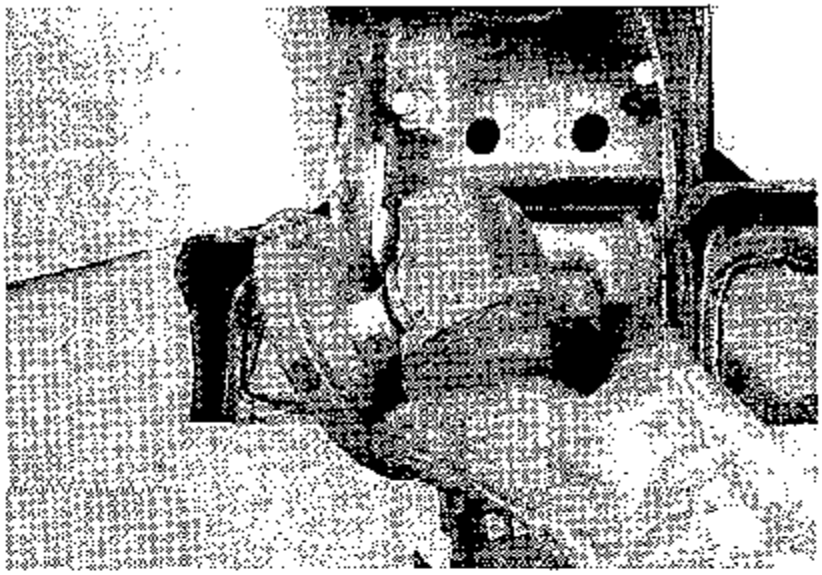
    NOTE: Do not weld corners of plate.



12. Check weld quality.

    (a) Using the disk grinder, remove any excessive weld material.

    (b) If there are any weld areas where the correct weld penetration was not obtained, grind and reweld.



7

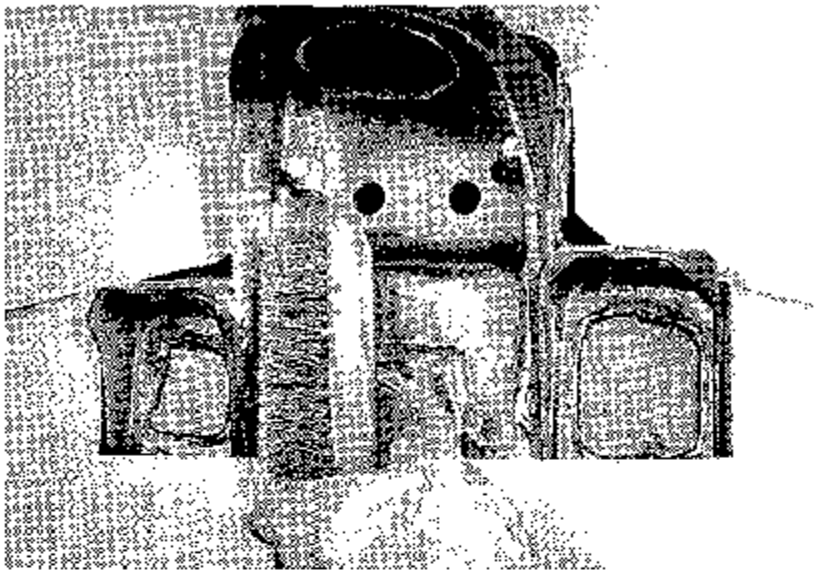
CLEANING AND REFINISHING

7

Cleaning and Refinishing

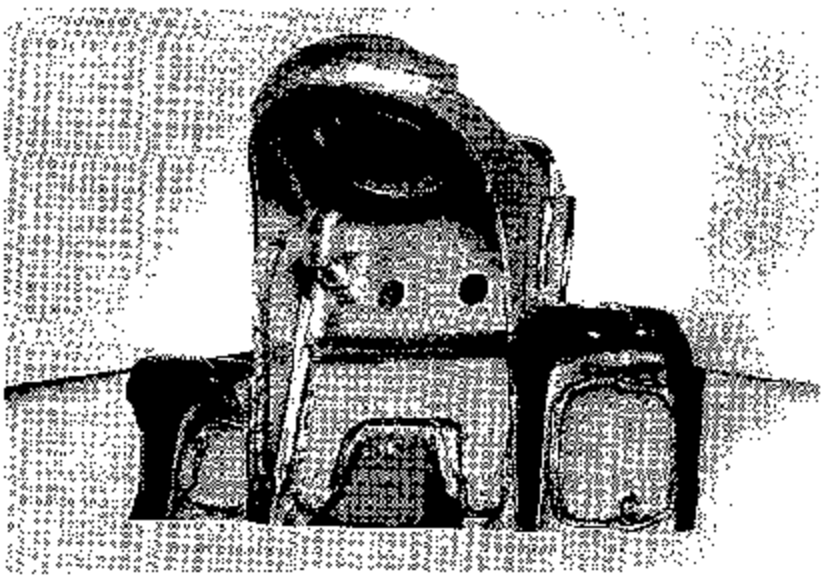
1. (a) Using a wire brush and shop air, clean off any burnt paint from the welding process.

NOTE: Be sure to remove burnt paint from the back side of the area to which the reinforcement plate is welded.



(b) Degrease weld area with Toyota Non-Chlorinated Brake Cleaner prior to repainting.

2. Paint the modified area using Rustoleum® Red Primer and Black Top Coat.
3. Remove spatter shields.
4. Check for proper paint finish after it has dried.

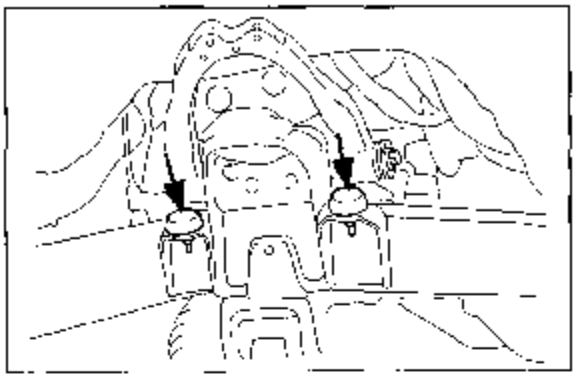


REASSEMBLY AND ALIGNMENT

Reassembly and Alignment

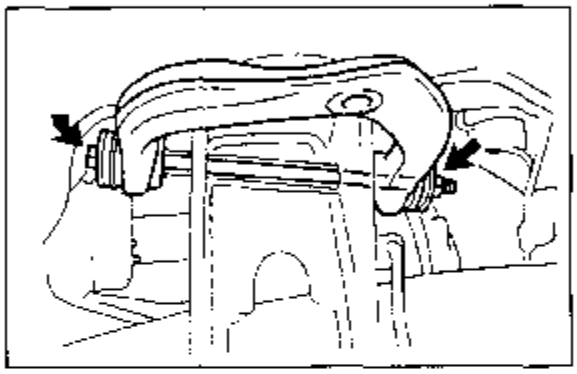
1. Reinstall the two (2) spring bumper stops.

   NOTE: Lubricate with silicone spray to ease reinstallation.



2. Loosen the two (2) upper suspension arm pivot bolts.

   Position the lower suspension arm with the steering knuckle and hub & rotor assembly and install the lower suspension arm pivot bolt.



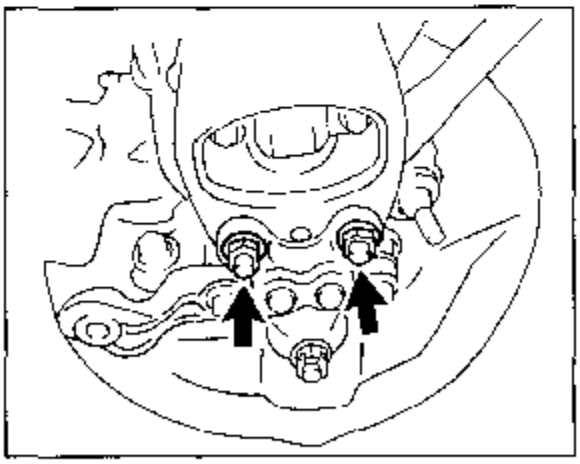
3. Using the spring compressor (SST 09727-22011-ST), carefully compress the spring by positioning the tool in the same positions used for disassembly.

   Gently compress the spring to approximately 11" long.

4. Reassemble the strut bar onto the lower suspension arm.

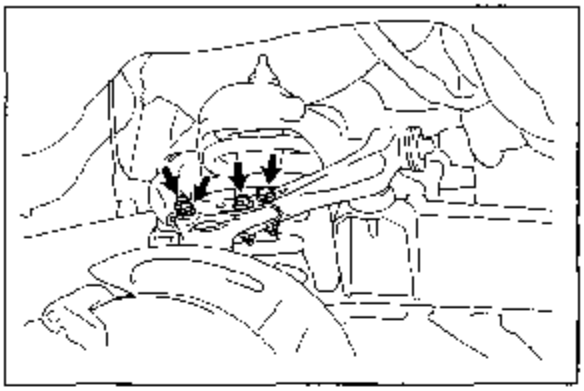
   NOTE: Do not tighten the two (2) nuts for the strut bar on the lower suspension arm.

5. With the compressed spring in one hand, lift up the lower suspension arm and steering knuckle assembly while positioning the spring between the upper spring mount and the lower suspension arm.

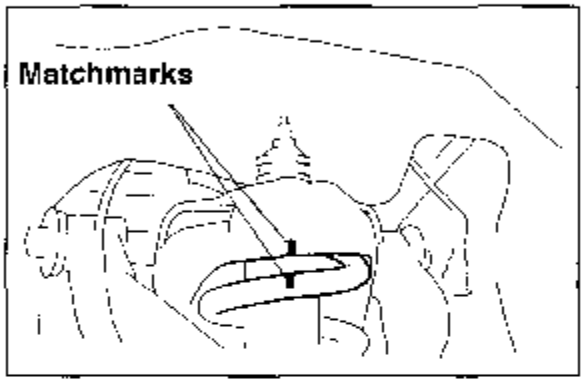


6. Reinsert the upper ball joint mounting into the upper suspension arm. Install and tighten the four (4) bolts and nuts.

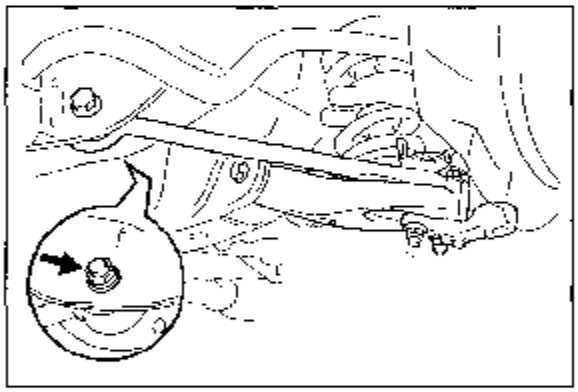
   Torque:
   39 N-m (400 Kg-cm, 29 ft-lb)



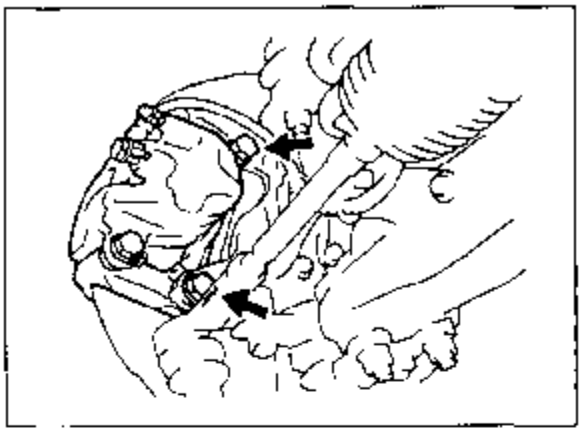
7. Decompress the coil spring, align the marked positions between the suspension support and the coil spring. Remove the spring compressor SST completely.



8. Reinstall the strut bar front pivot bolt, do not tighten at this time.



9. Reinstall the brake caliper, make certain there are no kinks or twist in the brake hose. Tighten the two (2) bolts onto the steering knuckle.



Torque:
108 N-m (1,100 Kg-cm, 80 ft-lb)

10. Reinstall the two (2) brake hose clamps.

Torque:
30 N-m (300 Kg-cm, 22 ft-lb)

11. Reinstall the ABS speed sensor and wire harness clamp (if equipped) onto the steering knuckle. Make certain there are no foreign objects on the magnetic sensor head.

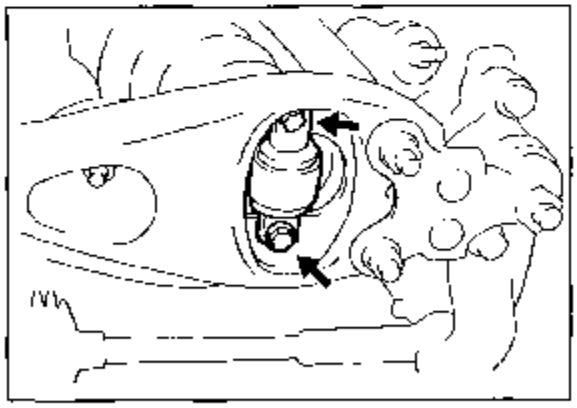
Torque:
8 N-m (82 Kg-cm, 71 in-lb)

12. Reinstall the tie rod end. Tighten the nut and install a new cotter pin.

Torque:
72 N-m (730 Kg-cm, 53 ft-lb)

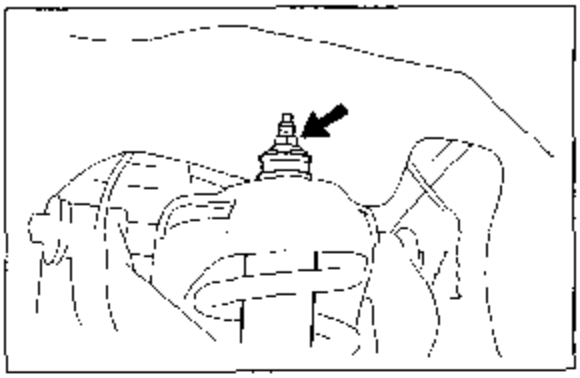
13. Reinstall shock absorber assembly.

(a) Position the shock absorber and reinstall the shock absorber and the two (2) bolts onto the lower suspension arm.



Torque:
39 N-m (400 Kg-cm, 29 ft-lb)

(b) Hold the shock absorber rod, then tighten the nut, retainer, cushion and shock absorber onto the suspension support.

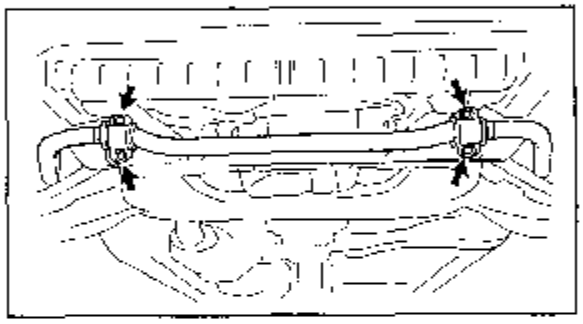


NOTE: Use a new nut (P/N: 94184-61000) on the top of the shock absorber as this is a non-reusable part.

Torque:
25 N-m (250 Kg-cm, 18 ft-lb)

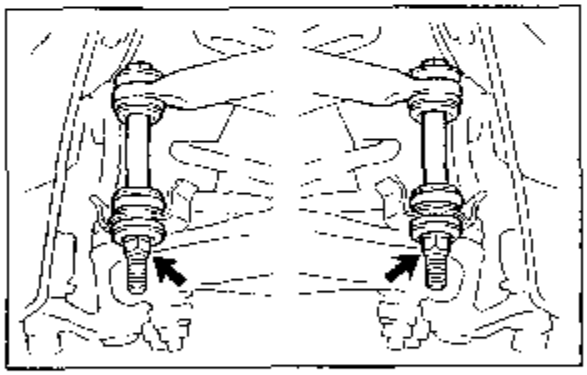
14. Repeat the same reinstallation procedures for the other side.

15. After both sides have been reassembled, the stabilizer bar can then be reinstalled.



(a) Reinstall the four (4) bolts and stabilizer bar with the cushions and brackets.

Torque:
29 N-m (300 Kg-cm, 22 ft-lb)



(b) Hold the bolt with a wrench, then reinstall the nut, retainer, collar and cushion of the stabilizer bar onto the lower suspension arm.

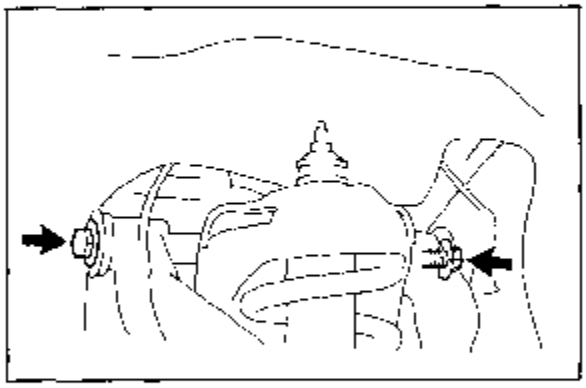
NOTE: Use a new nut (P/N: 94184-61000) on the stabilizer bar link bolt as this is a non-reusable part.

Torque:
39 N-m (400 Kg-cm, 29 ft-lb)

16. Reinstall the wheels.

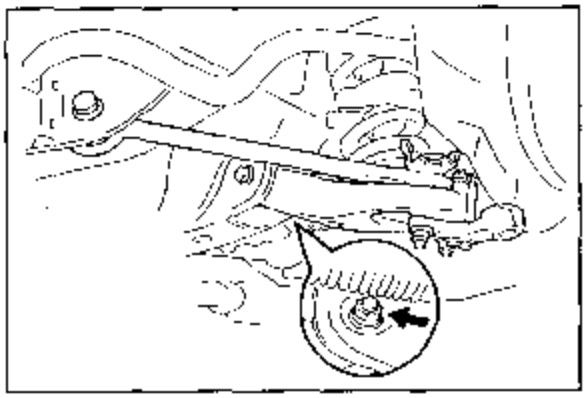
Torque:
110 N-m (1,150 Kg-cm, 83 ft-lb)

17. Lower the vehicle, after suspension has been set to normal ride height, then tighten the following bolts:



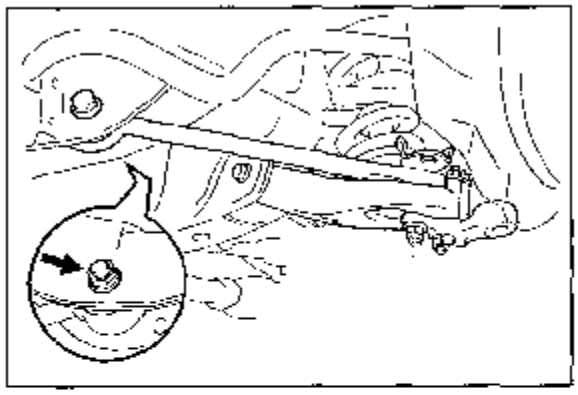
(a) Two (2) upper suspension arm pivot bolts.

Torque:
130 N-m (1,300 Kg-cm, 94 ft-lb)



(b) Lower suspension arm pivot bolt.

Torque:
200 N-m (2,050 Kg-cm, 148 ft-lb)



(c) Strut bar front pivot bolt.

Torque:
300 N-m (3,050 Kg-cm, 221 ft-lb)

(d) Two (2) nuts for the strut bar on the lower suspension arm.

Torque:
150 N-m (1,530 Kg-cm, 111 ft-lb)

18. Reconnect the negative (–) terminal cable on the battery.

19. Reset the clock and the radio stations preset by the customer.

20. Wheel Alignment and Road Test.

    Confirm that front wheel alignment is within specifications. If adjustment is required, refer to the repair manual specification under the applicable load conditions.

Tacoma 4x2
Wheel Alignment Specifications

Camber:	0°00´ ± 45´
Caster:	1°50´ ± 45´
Steering Axis Inclination:	10°00´ ± 45´
Toe-in (total):	0° ± 0.2° (0 ± 0.08 in.)

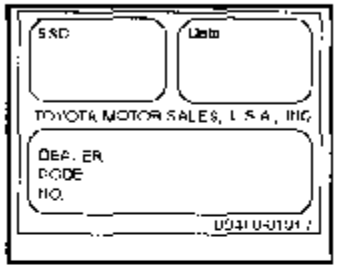
NOTE: Record alignment settings on Repair Order (RO).

21. SSC COMPLETION LABEL INSTALLATION

(a) After completing repair and before returning vehicle to the owner, a SSC completion label that is enclosed in the owner's notification must be affixed to the left front door hinge post above the check strap.

(b) The label is to be filled out as follows:

Write in SSC T06
Write in date of repair
Write in your Dealer Code



(c) Additional SSC completion labels, in sheets of 50 (P/N 00410-01917), may be ordered through the non-parts system on a 1450 order form or through the TDN system.

TOYOTA

96V-129

Toyota Motor Sales, U.S.A., Inc.
19001 South Western Avenue
P.O. Box 2991
Torrance, CA 90509-2991
(310)618-4000
(310)618-7800 Fax

URGENT

TO: ALL TOYOTA DEALER PRINCIPALS,
SERVICE MANAGERS, PARTS MANAGERS

SUBJECT: SPECIAL SERVICE CAMPAIGN - T06 **(UPDATE 7/11/96)**
(TACOMA 4x2 FRONT SUSPENSION SUPPORT)

Further to the original Preliminary Notice, this communication is to inform you of how to identify the involved vehicles and the reimbursement procedures for the Preliminary Inspection.

Federal Regulation prohibits the delivery of a new vehicle involved in a safety recall until the vehicle has been repaired. Consequently, it is vital that you DO NOT deliver confirmed involved Tacoma 4x2 vehicles without first performing the recall repair procedure. Tacomas received into inventory that are confirmed to be not involved may be delivered and operated without restriction.

A special repair procedure for both in-stock and customer vehicles is being developed to address this condition and complete instructions will be forwarded to you as soon as the details are finalized.

In addition, a special floor plan reimbursement procedure is being developed and will be communicated to you from your Regional Distribution Department when the details have been finalized

If you are contacted by customers, prior to the availability of repair procedures, who are concerned about continuing to operate their vehicles please perform the attached Updated Preliminary Inspection Procedure. Vehicles that exhibit no signs of cracking of the suspension support should be returned to the customer and continue to be operated until the owner notification occurs. If a vehicle is found to have any cracking of the suspension support, it must be physically inspected by a Regional Service Representative and if confirmed further arrangements will be made through the Regional Customer Relations Department.

1. Identification of Involved Vehicles

Please refer to the attached Updated Preliminary Inspection Procedures

2. Reimbursement Procedures

Submit Special Service Campaign claims following the procedures described in the Toyota Warranty Policy & Procedures Manual.

The operation codes to be used for this Preliminary Inspection are as follows:

SSC No.	Op. Code	Description	Flat Rate Hour
T06	6502G1	Preliminary Inspection for Owner	0.4 hrs/vehicle

Please review this entire package with your Service and Parts staff to familiarize them with the proper step-by-step procedure and implement this Special Service Campaign to ensure customer satisfaction.

Thank you for your cooperation.

TOYOTA MOTOR SALES, U.S.A., INC.

Enclosures

THIS INCLUDES IMPORTANT NEW INFORMATION

UPDATED [7/11/96]

PRELIMINARY INSPECTION PROCEDURES

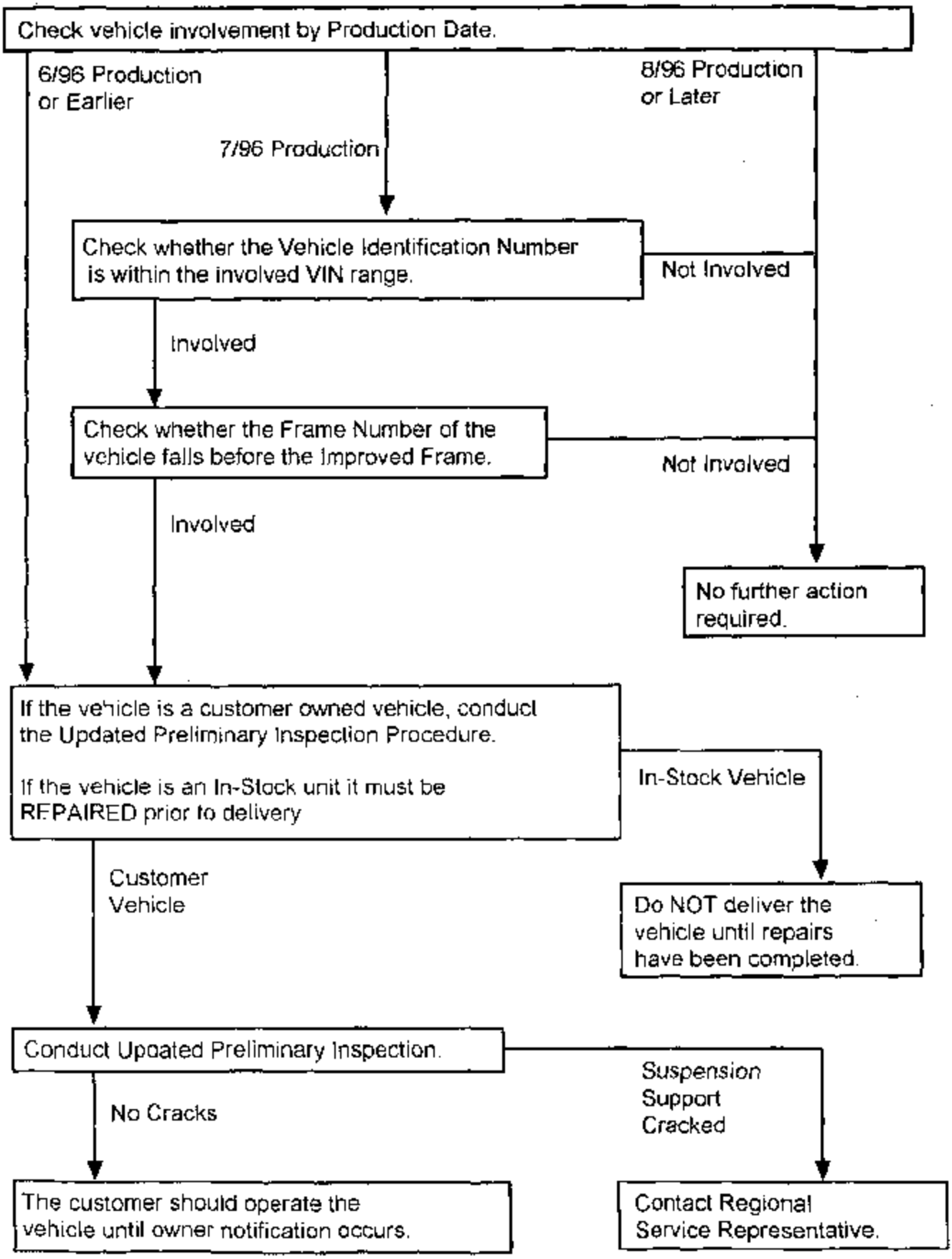
FOR

SPECIAL SERVICE CAMPAIGN T06

The section of the Updated Preliminary Inspection Procedures, titled "II. DETERMINING IF THE VEHICLE IS INVOLVED" will assist you in determining whether an IN-STOCK vehicle is involved in SSC T06. Non-involved units may be delivered and operated without restriction, however, Federal Regulation requires that involved IN-STOCK VEHICLES be REPAIRED prior to delivery.

Please discard the Updated Preliminary Inspection Procedures once the Repair Procedures are made available.

I. OPERATION FLOW CHART

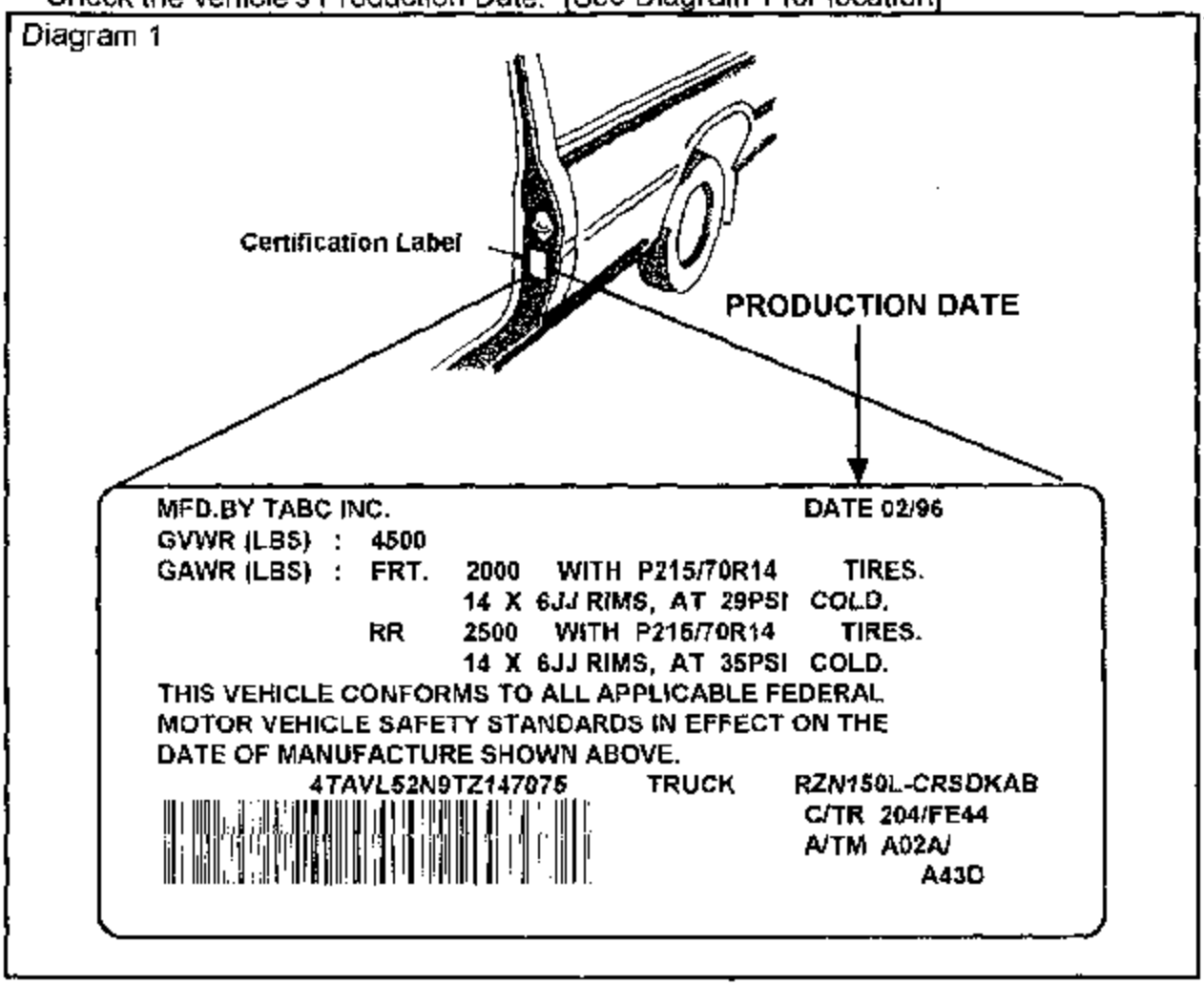


II. DETERMINING IF THE VEHICLE IS INVOLVED

1. CHECK VEHICLE INVOLVEMENT BY PRODUCTION DATE

Check the vehicle's Production Date. [See Diagram 1 for location]

Diagram 1



① If the vehicle was manufactured **during or prior** to **June 1996**, the vehicle is **INVOLVED** in SSC T06.

② If the vehicle was manufactured during July 1996, proceed with the VIN range check to determine if the vehicle is involved.

③ Vehicles manufactured in **August 1996** and **later** are **NOT INVOLVED** in SSC T06 and may be delivered and operated without restriction.

⇦ 06/96	07/96	08/96 ⇨
INVOLVED in SSC T06	Proceed with VIN Range Check	NOT INVOLVED in SSC T06

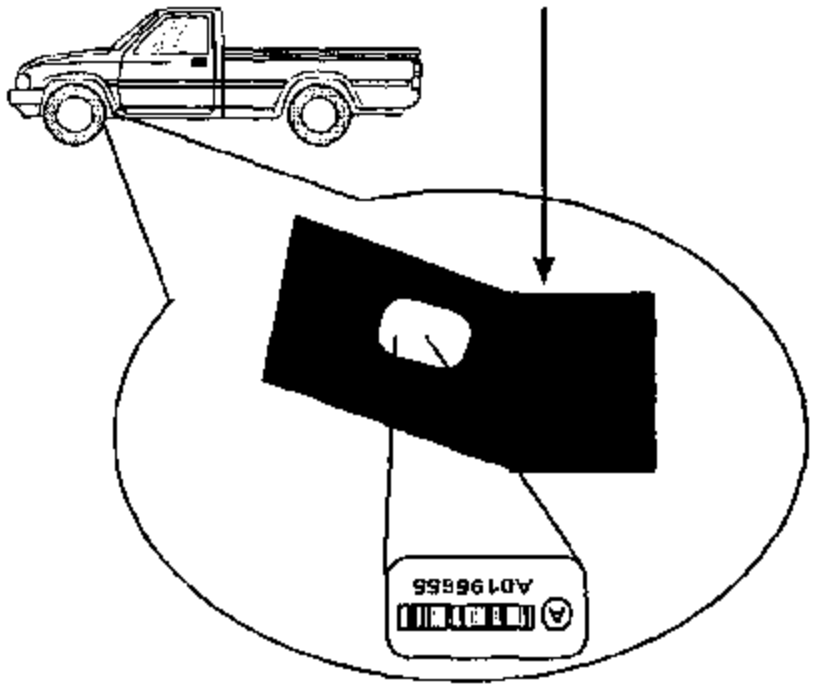
2. CHECK VEHICLE INVOLVEMENT BY VIN
For vehicles produced in July 1996, check the VIN range to determine if the vehicle is involved in SSC T06. If the vehicle is outside of the VIN range it is not involved.

Model	VDS		Transmission	VIN Ranges*
	1995	1996		
Tacoma 4x2	4TAUN41B	4TANL42N	Manual	Z000001 - Z196728
			Automatic	Z000001 - Z196765
	4TAUN53B	4TAVL52N	Manual	Z000001 - Z197076
			Automatic	Z000001 - Z197072
	4TAVN53F	4TAVN52N	Both A/T & M/T	Z000001 - Z197100

VIN Range starting after the Model Year Indicator (S = 1995, T = 1996).

3. CHECK VEHICLE INVOLVEMENT BY FRAME NUMBER
For those vehicles produced in July 1996 and fall within the VIN range, check the Frame Number to determine if the vehicle is equipped with an involved Frame or an Improved Frame (NOT INVOLVED). [See Diagram 2 for Frame Number location]

Diagram 2



Please note the Frame Number Label is installed **upside down** on the Frame.

STARTING FRAME NUMBERS FOR IMPROVED FRAME

Model	VDS	Transmission		Starting Frame No. for Improved Frame*
	1996			
Tacoma 4x2	4TANL42N	Manual	A	0195396 -
		Automatic	B	
	4TAVL52N	Manual	C	
		Automatic	D	
	4TAVN52N	Both A/T & M/T	E	

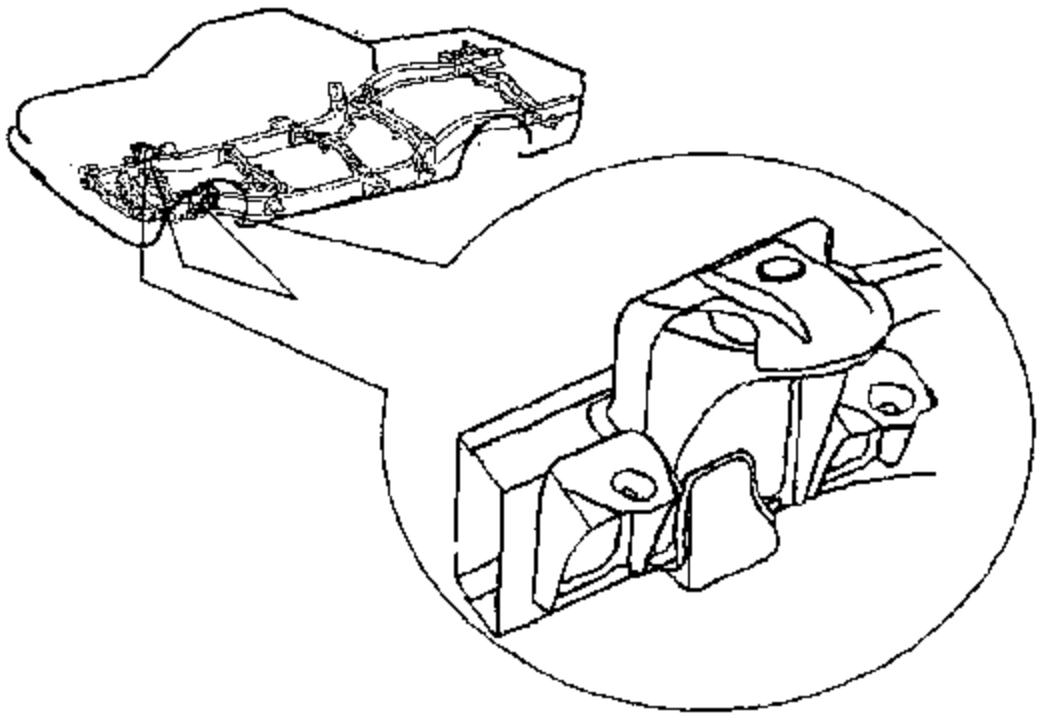
*Vehicles built with these Frames and later are NOT INVOLVED in SSC T06

III. NECESSARY TOOLS

- Standard Tools
- Flashlight

IV. INSPECTION PROCEDURES

Diagram 3
(Area to be inspected)



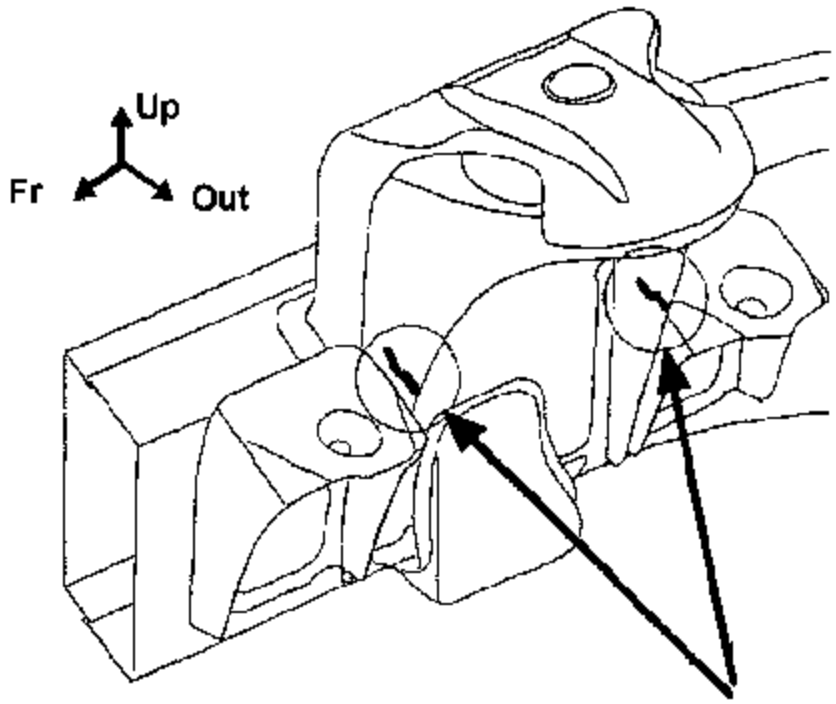
FRONT SUSPENSION SUPPORTS

1. Inspect only **Customer** vehicles, if requested by the customer, which you have determined to be involved in SSC T06 using the preceding steps. **Federal Regulation requires that IN-STOCK VEHICLES be REPAIRED prior to delivery.**

2. Raise the vehicle on a hoist.

3. Remove both front wheels.
   Locate the front suspension supports
   [See Diagram 3]

Diagram 4



4. Carefully conduct a visual inspection of the areas indicated (both driver and passenger sides) for any signs of cracking.
[See Diagram 4]

5 If there are no signs of cracking of the suspension support, the vehicle should be operated until the owner notification occurs and the vehicle is repaired.

If a vehicle is found to have any cracking of the suspension support, it must be physically inspected by a Regional Service Representative and if confirmed, further arrangements will be made through the Regional Customer Relations Department.

Please discard the Updated Preliminary Inspection Procedures once the Repair Procedures are made available.

96V-129

TOYOTA

TOYOTA MOTOR SALES, U.S.A., INC.

Technical Compliance

Volume: V
Number: TC96-009
Date: 7/10/96
X Action
X Retain
___ Information

URGENT

TO: ALL REGIONAL/PRIVATE DISTRIBUTOR GENERAL MANAGERS

FROM: B. PORENTO

SUBJECT: SPECIAL SERVICE CAMPAIGN - T06 **(UPDATE)**
(TACOMA 4x2 FRONT SUSPENSION SUPPORT)

Further to the Preliminary Notice of July 9, 1996, this update is to inform you of the following additional details:

- The attached updated information is being sent to all dealers July 11, via overnight mail. It will enable them to identify involved vehicles and provide them with the reimbursement instructions for performing the Preliminary Inspection for customers who may learn of this problem and are concerned about continuing to operate their vehicle.

- If a vehicle is inspected and found to exhibit no signs of cracking, but the customer expresses serious concern about continuing to drive the vehicle until the repair is available please have your Customer Relations Department arrange for a loaner vehicle. This may include the possibility that there will be a need to provide a commercial vehicle loaner.

- As described in the Preliminary Notice and explained at the video conference, a floor plan assistance program is being developed and will be informed to you by National Vehicle Distribution.

- It is intended that the welding portion of the repair be performed by a certified/professional welder who is experienced with MIG welding. Further details as to the selection and qualification of welders will be provided at Technical Training in Torrance on July 18, and in the final Technical Instructions.

Thank you for your cooperation.

TOYOTA MOTOR SALES, U.S.A., INC.

Enclosures

c: Region/Private Distributor Service Managers
Region/Private Distributor District Service Managers
Region/Private Distributor Customer Relations Managers
Region/Private Distributor Distribution Managers
Region/Private Distributor Parts Managers
Region/Private Distributor District Parts Managers
Region/Private Distributor Assistant General Managers
Region/Private Distributor Field Technical Staff
All TMS Sales Administration Managers
All TMS Product Technical Department Managers
All Field Product Engineers
B. Daly
J. Daly
D. Danzer
F. Fontanella
T. Fujita
R. Gallio
Y. Gieszl
D. Illingworth
Y. Inaba
T. Ishikawa
Y. Ishizaka
M. Iwai
G. Kunkle
R. Maling
J. Matt
I. Miller
M. Naito
J. Olson
B. Plourde Jr.
B. Skiles
H. Yukawa

TOYOTA

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19001 South Western Avenue
P.O. Box 2991
Torrance, CA 90509-2991
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(310)618-7600 Fax

URGENT

TO: ALL TOYOTA DEALER PRINCIPALS,
SERVICE MANAGERS, PARTS MANAGERS

SUBJECT: SPECIAL SERVICE CAMPAIGN - T06 **(UPDATE 7/11/96)**
(TACOMA 4x2 FRONT SUSPENSION SUPPORT)

Further to the original Preliminary Notice, this communication is to inform you of how to identify the involved vehicles and the reimbursement procedures for the Preliminary Inspection.

Federal Regulation prohibits the delivery of a new vehicle involved in a safety recall until the vehicle has been repaired. Consequently, it is vital that you DO NOT deliver confirmed involved Tacoma 4x2 vehicles without first performing the recall repair procedure. Tacomas received into inventory that are confirmed to be not involved may be delivered and operated without restriction.

A special repair procedure for both in-stock and customer vehicles is being developed to address this condition and complete instructions will be forwarded to you as soon as the details are finalized.

In addition, a special floor plan reimbursement procedure is being developed and will be communicated to you from your Regional Distribution Department when the details have been finalized.

If you are contacted by customers, prior to the availability of repair procedures, who are concerned about continuing to operate their vehicles please perform the attached Updated Preliminary Inspection Procedure. Vehicles that exhibit no signs of cracking of the suspension support should be returned to the customer and continue to be operated until the owner notification occurs. If a vehicle is found to have any cracking of the suspension support, it must be physically inspected by a Regional Service Representative and if confirmed further arrangements will be made through the Regional Customer Relations Department.

1. Identification of Involved Vehicles

Please refer to the attached Updated Preliminary Inspection Procedures

2. Reimbursement Procedures

Submit Special Service Campaign claims following the procedures described in the Toyota Warranty Policy & Procedures Manual.

The operation codes to be used for this Preliminary Inspection are as follows:

SSC No.	Op. Code	Description	Flat Rate Hour
T06	6502G1	Preliminary Inspection for Owner	0.4 hrs/vehicle

Please review this entire package with your Service and Parts staff to familiarize them with the proper step-by-step procedure and implement this Special Service Campaign to ensure customer satisfaction.

Thank you for your cooperation.

TOYOTA MOTOR SALES, U.S.A., INC.

Enclosures

THIS INCLUDES IMPORTANT NEW INFORMATION

UPDATED [7/11/96]

PRELIMINARY INSPECTION PROCEDURES

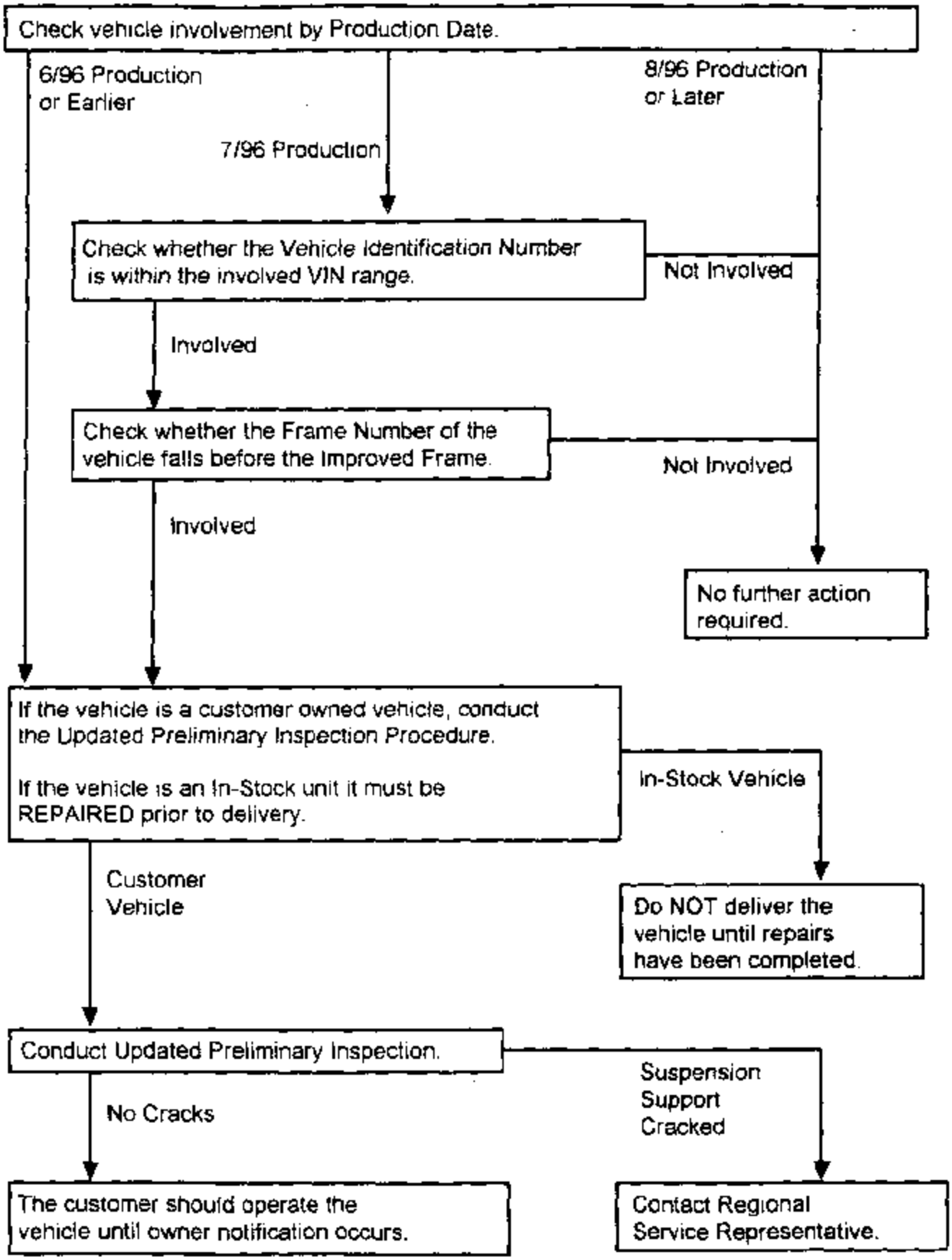
FOR

SPECIAL SERVICE CAMPAIGN T06

The section of the Updated Preliminary Inspection Procedures, titled "II. DETERMINING IF THE VEHICLE IS INVOLVED" will assist you in determining whether an IN-STOCK vehicle is involved in SSC T06. Non-involved units may be delivered and operated without restriction, however, Federal Regulation requires that involved IN-STOCK VEHICLES be REPAIRED prior to delivery.

Please discard the Updated Preliminary Inspection Procedures once the Repair Procedures are made available.

I. OPERATION FLOW CHART

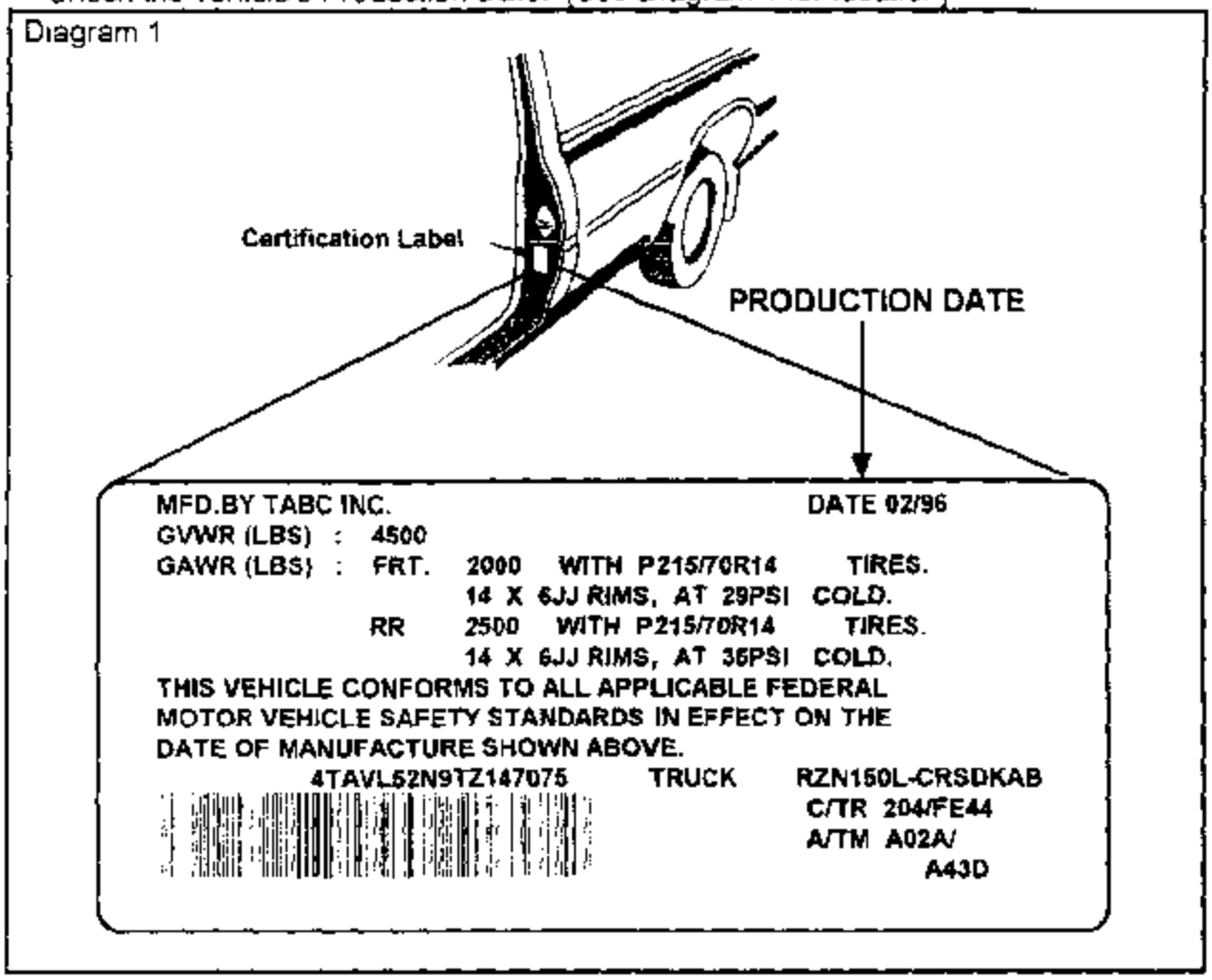


II. DETERMINING IF THE VEHICLE IS INVOLVED

1. CHECK VEHICLE INVOLVEMENT BY PRODUCTION DATE

Check the vehicle's Production Date. (See Diagram 1 for location)

Diagram 1



① If the vehicle was manufactured **during or prior** to **June 1996**, the vehicle is **INVOLVED** in SSC T06.

② If the vehicle was manufactured during July 1996, proceed with the VIN range check to determine if the vehicle is involved.

③ Vehicles manufactured in **August 1996** and **later** are **NOT INVOLVED** in SSC T06 and may be delivered and operated without restriction.

⇦ 06/96	07/96	08/96 ⇨
INVOLVED in SSC T06	**Proceed with VIN Range Check**	**NOT INVOLVED in SSC T06**

2. CHECK VEHICLE INVOLVEMENT BY VIN

For vehicles produced in July 1996, check the VIN range to determine if the vehicle is involved in SSC T06. If the vehicle is outside of the VIN range it is not involved.

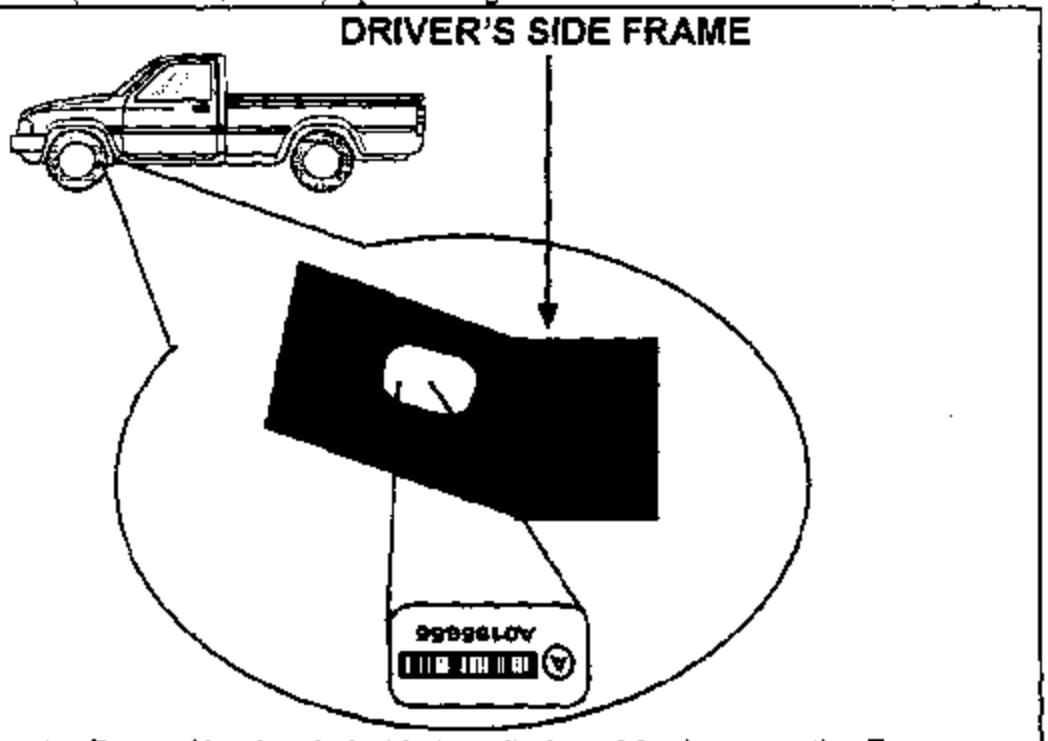
Model	VDS		Transmission	VIN Ranges*
	1995	1996		
Tacoma 4x2	4TAUN41B	4TANL42N	Manual	Z000001 - Z196728
			Automatic	Z000001 - Z196765
	4TAUN53B	4TAVL52N	Manual	Z000001 - Z197076
			Automatic	Z000001 - Z197072
	4TAVN53F	4TAVN52N	Both A/T & M/T	Z000001 - Z197100

VIN Range starting after the Model Year Indicator (S = 1995, T = 1996).

3. CHECK VEHICLE INVOLVEMENT BY FRAME NUMBER

For those vehicles produced in July 1996 and fall within the VIN range, check the Frame Number to determine if the vehicle is equipped with an involved Frame or an Improved Frame (NOT INVOLVED). [See Diagram 2 for Frame Number location]

Diagram 2



Please note the Frame Number Label is installed **upside down** on the Frame.

STARTING FRAME NUMBERS FOR IMPROVED FRAME

Model	VDS	Transmission		Starting Frame No. for Improved Frame*
	1996			
Tacoma 4x2	4TANL42N	Manual	A	0195396 -
		Automatic	B	
	4TAVL52N	Manual	C	
		Automatic	D	
	4TAVN52N	Both A/T & M/T	E	

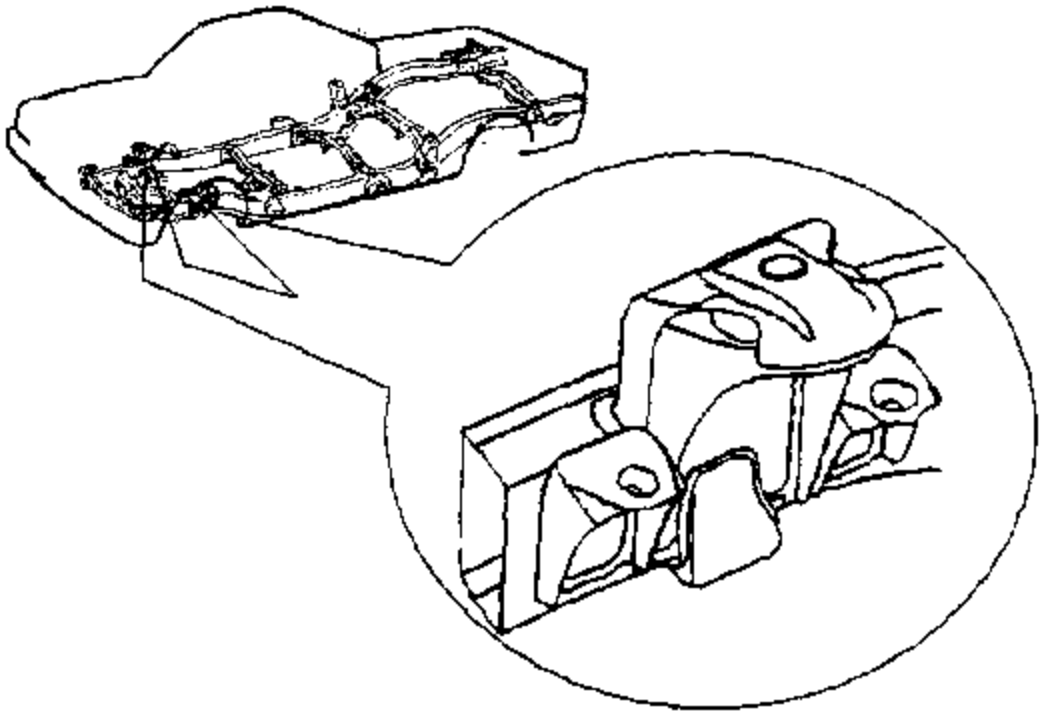
*Vehicles built with these Frames and later are NOT INVOLVED in SSC T06

III. NECESSARY TOOLS

- Standard Tools
- Flashlight

IV. INSPECTION PROCEDURES

Diagram 3
(Area to be inspected)



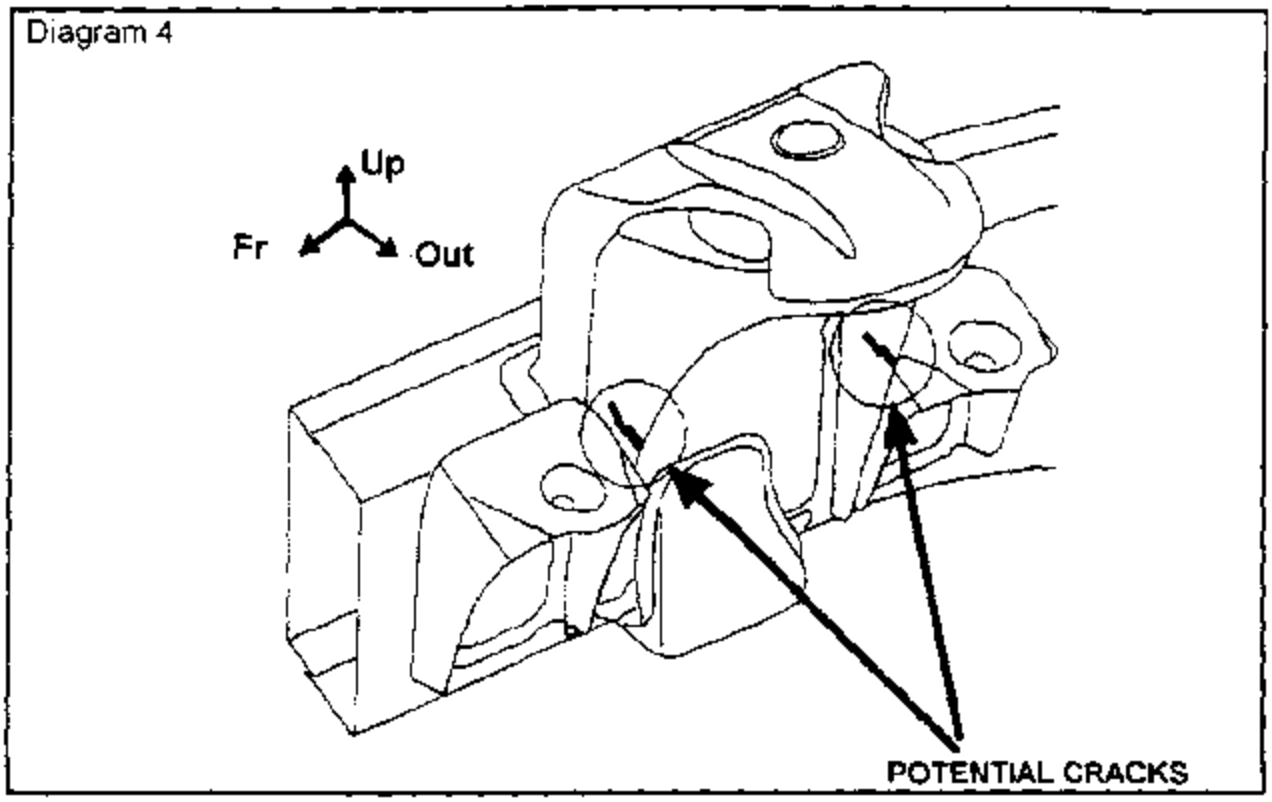
FRONT SUSPENSION SUPPORTS

1 *Inspect only* **Customer** vehicles, if requested by the customer, which you have determined to be involved in SSC T06 using the preceding steps. **Federal Regulation requires that IN-STOCK VEHICLES be REPAIRED prior to delivery.**

2. Raise the vehicle on a hoist.

3. Remove both front wheels.
   Locate the front suspension supports
   [See Diagram 3]

Diagram 4



4. Carefully conduct a visual inspection of the areas indicated (both driver and passenger sides) for any signs of cracking.
   [See Diagram 4]

5. If there are no signs of cracking of the suspension support, the vehicle should be operated until the owner notification occurs and the vehicle is repaired.

   If a vehicle is found to have any cracking of the suspension support, it must be physically inspected by a Regional Service Representative and if confirmed, further arrangements will be made through the Regional Customer Relations Department.

Please discard the Updated Preliminary Inspection Procedures once the Repair Procedures are made available.

96V-129

TOYOTA

TOYOTA MOTOR SALES, U.S.A., INC.

Technical Compliance

Volume: V
Number: TC96-010
Date: 7/22/96
_X_ Action
_X_ Retain
___ Information

TO: ALL REGIONAL/PRIVATE DISTRIBUTOR GENERAL MANAGERS

FROM: B. PORENTO,
CORPORATE PRODUCT TECHNICAL MANAGER

SUBJECT: SPECIAL SERVICE CAMPAIGN - T06 **(UPDATE)**
(TACOMA 4x2 FRONT SUSPENSION SUPPORT)

We have received confirmation from TMC that the flooring costs for **used** Tacoma 4x2 vehicles that are held in dealer inventory pending the availability of the modification are eligible for reimbursement.

Further information as to the details of applying for this reimbursement will be forwarded to you by the National Distribution Department.

To inform dealers of the availability of this additional floor plan assistance, the attached letter is being sent to all Toyota dealers on July 24, 1996 (copy attached).

Thank you for your cooperation.

TOYOTA MOTOR SALES, U.S.A., INC.

Enclosures

c: Region/Private Distributor Service Managers
Region/Private Distributor District Service Managers
Region/Private Distributor Customer Relations Managers
Region Private Distributor Distribution Managers
Region/Private Distributor Assistant General Managers
All TMS Sales Administration Managers

D. Danzer	M. Iwai	B. Skiles
F. Fontanella	G. Kunkle	H. Yukawa
T. Fujita	R. Maling	
R. Gallio	J. Matt	
Y. Gieszl	I. Miller	
D. Illingworth	M. Naito	
Y. Inaba	J. Olson	
T. Ishikawa	B. Plourde, Jr.	

TOYOTA

July 24, 1996

Toyota Motor Sales, U.S.A., Inc.
19001 South Western Avenue
P.O. Box 2991
Torrance, CA 90509-2991
(310) 618-4000
(310) 618-7808 Fax

TO: ALL TOYOTA DEALER PRINCIPALS

SUBJECT: TACOMA 4x2 USED VEHICLES INVOLVED IN SPECIAL SERVICE CAMPAIGN T06 (FRONT SUSPENSION SUPPORT)

In May, 1994, Toyota sent a letter (copy attached) to all dealers to request cooperation in performing safety recall repairs on any used vehicles in dealer inventory prior to delivery of the vehicle to a customer. As a result of the current Special Service Campaign T06 for Tacoma 4x2 front suspension support, we request that you do not deliver any involved used Tacoma 4x2's without first performing the modification.

A special floor plan reimbursement procedure is being developed to support this effort and will be forwarded to your Region/Private Distributor Distribution Department when the details have been finalized.

Your continued efforts to ensure that all Toyota vehicles on the road today are in the safest possible condition are very much appreciated.

TOYOTA MOTOR SALES, U.S.A., INC.

CORPORATE PRODUCT TECHNICAL DEPARTMENT

Attachment

TOYOTA

Toyota Motor Sales, U.S.A., Inc.
19001 South Western Avenue
P.O. Box 2991
Torrance, CA 90509-2991
(310) 618-4900
(310) 618-7800 Fax

May 12, 1994

TO: ALL TOYOTA DEALER PRINCIPALS

SUBJECT: TOYOTA USED VEHICLE SAFETY RECALL REPAIRS

The National Highway Traffic Safety Administration ("NHTSA") has requested Toyota's cooperation in ensuring that all applicable safety recall campaign repairs are performed on used Toyota vehicles prior to resale.

Please ask your sales and service staff to confirm that any used Toyota vehicles currently in your inventory have had all applicable safety recall campaign repairs performed prior to resale. In addition, please ensure that any used Toyota vehicles added to your inventory in the future are also inspected and repaired as necessary.

Your continued efforts to ensure that all Toyota vehicles on the road today are in the safest possible condition are very much appreciated.

TOYOTA MOTOR SALES, U.S.A., INC.

CORPORATE TECHNICAL SERVICES

TOYOTA

TOYOTA MOTOR CORPORATE SERVICES OF NORTH AMERICA, INC.

WASHINGTON OFFICE
1850 M STREET, N.W., WASHINGTON, D.C. 20036

TEL: (202) 775-1707
FAX: (202) 463-8513

July 31, 1996

Mr. Michael Brownlee
Associate Administrator for Safety Assurance
National Highway Traffic Safety Administration
400 Seventh Street, S.W.
Washington, D.C. 20590

RE: Subject 96V-129; Tacoma 2WD Front Suspension Recall
Owner Notification Letter

Dear Mr. Brownlee:

Concerning the above-referenced recall campaign for the 1995-1996 Toyota Tacomas, we are submitting a copy of our Owner Notification Letter which will be sent to the subject owners. Please note, the notification letter will be sent to the subject owners soon, so if you have any comments please let us know as soon as possible.

If you have any questions, please contact Mr. Jim Ohashi of my staff at (202) 775-1707.

Sincerely yours,

TOYOTA MOTOR CORPORATE SERVICES
OF NORTH AMERICA, INC.

Saburo Inui
Vice President

SI:mh
Attachment

SSC T06 - 1995 to 1996 TACOMA 4X2 VEHICLE FRONT SUSPENSION SUPPORT SAFETY RECALL NOTICE

Dear Toyota Owner:

This notice is being sent to you in accordance with the requirement of the National Traffic and Motor Vehicle Safety Act. Toyota has determined that a defect related to the front suspension supports exists in 1995 and certain 1996 model year Tacoma 4X2 vehicles.

WHAT IS THE PROBLEM?

If the front suspension supports of 1995 and certain 1996 model year Tacoma 4X2's are subjected to certain repeated driving conditions, such as simultaneous vertical and horizontal loading, (e.g. driving over a speed bump under severe braking), it may develop a crack, which could ultimately lead to failure of the front suspension support, possibly resulting in the loss of vehicle control.

WHAT WILL TOYOTA DO?

Any Toyota dealer will install a reinforcement kit to the front suspension supports at **NO COST** to you.

WHAT SHOULD YOU DO?

Contact any authorized Toyota dealer and make an appointment to have the necessary modification performed as soon as possible.

The labor time for installation of the reinforcement kit is approximately 6 hours. However, depending upon the dealer's work schedule, it may be necessary to make your vehicle available for a longer period of time.

Please present this notice to the dealer when you bring the vehicle in for the repair.

If you no longer own the vehicle, please indicate so on the enclosed postage paid form, providing us with the name and address of the new owner.

WHAT IF YOU HAVE OTHER QUESTIONS?

Please contact any Toyota dealer or call the Toyota Customer Assistance Center at 1-800-331-4331.

If you believe that the dealer or Toyota has failed or is unable to remedy the defect within a reasonable time, you may submit a complaint to the Administrator, National Highway Traffic Safety Administration, 400 Seventh Street S.W., Washington, D.C. 20590, or call the toll free Auto Safety Hot Line at 800-424-9393 (Washington, D.C. area residents may call 366-0123).

We have sent this notice in the interest of your continued satisfaction with our products and we sincerely regret any inconvenience this condition may have caused you.

Thank you for driving a Toyota.

Sincerely,

TOYOTA MOTOR SALES, U.S.A., INC.
CORPORATE PRODUCT TECHNICAL DEPARTMENT

TOYOTA

TOYOTA MOTOR CORPORATE SERVICES OF NORTH AMERICA, INC.

WASHINGTON OFFICE
1850 M STREET, N.W., WASHINGTON, D.C. 20036

TEL: (202) 775-1707
FAX: (202) 463-8513

August 6, 1996

Mr. Michael Brownlee
Associate Administrator for Safety Assurance – NSA-01
National Highway Traffic Safety Administration
400 Seventh Street, S.W.
Washington, D.C. 20590

Re: Subject 96V-129; Tacoma 2WD Front Suspension Recall
Supplemental Information: VIN Ranges and Number of Vehicles

Dear Mr. Brownlee:

On July 9, 1996 we submitted a defect information report for the above referenced recall. We explained at that time that we would furnish the missing information on the affected VIN ranges, and the total number of vehicles potentially affected as soon as it became available. That information is as follows:

2. Identification of Affected Vehicles:

Make/ Car Line	Model Year	Manufacturer	VIN		Production Period
			VDS	VIS	
Toyota Tacoma 2WD	1995-1996	TABC Inc.	UN41B	Z000002~Z085525	January 13, 1995 through July 19, 1996
			UN53B	Z000001~Z085531	
			VN53F	Z000007~Z085518	
			NL42N	Z085537~Z196763	
			VL52N	Z085532~Z197073	
			VN52N	Z085538~Z197007	

Note : Although the involved vehicles are within the above VIN ranges, not all vehicles in these ranges were sold in the U.S.

3. Total Number of Vehicles Potentially Affected:

88,987 units

Should you have any questions about this report, please contact Mr. Jim Ohashi of my staff at (202) 775-1707.

Sincerely,

TOYOTA MOTOR CORPORATE
SERVICES OF NORTH AMERICA, INC.

Saburo Inui
Vice President

SI:jo

TOYOTA

TOYOTA MOTOR CORPORATE SERVICES OF NORTH AMERICA, INC.

WASHINGTON OFFICE
1850 M STREET, N.W., WASHINGTON, D.C. 20036

TEL: (202) 775-1707
FAX: (202) 463-8513

August 20, 1996

Mr. Jonathan D. White, Chief
Recall Analysis Division
Office of Defects Investigation, Safety Assurance
National Highway Traffic Safety Administration
400 Seventh Street, S.W.
Washington, D.C. 20590

RE: Subject 96V-129; Tacoma 2WD Front Suspension DIR

Dear Mr. White:

This is in response to your letter dated August 14, 1996 regarding additional information for the above referenced recall.

The manufacturing dates of the vehicles involved in the recall were supplied in a letter to Mr. Michael Brownlee, dated August 6, 1996. We have enclosed a copy of that letter for your convenience.

Also, a draft of the owner notification letter was sent to the Recall Analysis Division, and the letter was approved on July 30, 1996. A copy of the approval notice is also attached for your convenience.

If you have any questions, please contact Mr. Hiroshi Hagiwara of my staff at (202) 775-1707.

Sincerely yours,

TOYOTA MOTOR CORPORATE SERVICES
OF NORTH AMERICA, INC.

Saburo Inui
Vice President

SI:mh
Attachments

TOYOTA

TOYOTA MOTOR CORPORATE SERVICES OF NORTH AMERICA, INC.

WASHINGTON OFFICE
1850 M STREET, N.W., WASHINGTON, D.C. 20036

TEL: (202) 775-1707
FAX: (202) 463-8513

August 6, 1996

Mr. Michael Brownlee
Associate Administrator for Safety Assurance – NSA-01
National Highway Traffic Safety Administration
400 Seventh Street, S.W.
Washington, D.C. 20590

Re: Subject 96V-129; Tacoma 2WD Front Suspension Recall
Supplemental Information: VIN Ranges and Number of Vehicles

Dear Mr. Brownlee:

On July 9, 1996 we submitted a defect information report for the above referenced recall. We explained at that time that we would furnish the missing information on the affected VIN ranges, and the total number of vehicles potentially affected as soon as it became available. That information is as follows.

2. Identification of Affected Vehicles:

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Toyota Tacoma 2WD	1995-1996	TABC Inc.	UN41B	Z000002~Z085525	January 13, 1995 through July 19, 1996
			UN53B	Z000001~Z085531	
			VN53F	Z000007~Z085518	
			NL42N	Z085537~Z196763	
			VL52N	Z085532~Z197073	
			VN52N	Z085538~Z197007	

Note : Although the involved vehicles are within the above VIN ranges, not all vehicles in these ranges were sold in the U.S.

3. Total Number of Vehicles Potentially Affected:

88,987 units

Should you have any questions about this report, please contact Mr. Jim Ohashi of my staff at (202) 775-1707.

Sincerely,

TOYOTA MOTOR CORPORATE
SERVICES OF NORTH AMERICA, INC

Saburo Inui
Vice President

SI:jo

AUG 1 1996

ACKNOWLEDGEMENT FAX SHEET OF RECEIPT OF DEALER/OWNER NOTIFICATION DOCUMENTS SUBMITTED UNDER 49 CFR PART 577.6

Assigned Recall No. 96V-129 by the
National Highway Traffic Safety Administration

Part 577 Report Date: **July 31, 1996**

MANUFACTURER: **Toyota Motor Corporate Services of North America, Inc.**

MANUFACTURER CONTACT: **Saburo Inui, Vice President**

FAX: **(202) 463-8513**

SUBJECT: **90,000 Toyota 1995-1996 Tacoma 2WD model vehicles. Under certain driving conditions, the front suspension can crack leading to the failure of the support.**

NOTIFICATION TO PURCHASERS:

We have reviewed your proposed owner notification letter and it meets the requirements of Part 577.

Notes: Toyota Campaign SSC T06.

If you have any questions, please call:

Pat Wallace, Safety Defects Analyst, or Jonathan White, Chief
on (202) 366-5227 or by FAX (202) 366-7882
Recall Analysis Division